



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No. CNC/QA/FM/02
 Rev. No. 01
 Rev. Date 31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11165	33/33/66
2	Machined By		V.T.L. n/c Shop	31/07/2013
3	Pallet Die No.		11479 (G.O) n/c	Rev 2.1
4	Die Category	Drg. No.	H. Jumbo	(B)
5	Out Side Diameter	Drg. No.	680.6 n/c Step OD: 692.8 n/c	Tapping 3"
6	Inside Diameter	Drg. No.	548.14 n/c	Step length 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut: 2.4 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c 32 x 7 x 8 n/c (4 x 3)	Face side step 31 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Deep Bottom side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes = 4
12	Tapping PCD		619 n/c	Bottom side
13	Tapping Hole Diameter		NIG 2 Check by NIG B. 12	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.4 n/c	Tapping Depth 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 2/8/14

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		No

Note: Mark the defective holes/Missed holes with the help of Permanent Marker Count on 30°

1	Counter Sinking Depth & Finish	ok							Rep 12
2	External Relief Dia	6.5 n/c 7.5 n/c	6.5 n/c	All Rows	7.5 n/c	All Rows			
3	External Relief Depth		33 n/c		98 n/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		2	2	24				

Inspected By (Sign) & Date Ravi 2/8/14

Reviewed by (Engineer-CNC) Satyam 2/2/14

Manager-QA