



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)

691

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11256	38/55
2	Machined By		V.T.L n/c Shop	Drig No. 1.80-408
3	Pallet Die No.		11573 (4.0) n/c	Row 200
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	710 n/c	Step OD = 692.8 n/c
6	Inside Diameter	Drg. No.	600.12 n/c	Tabber 212
7	Width of Pellet Die	Drg. No.	222 n/c	Step length = 198
8	Grooves as per Drawing	Drg. No.	12x2x7 n/c / 12x2x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No of Holes = 12 Rota side
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.4 n/c	Tabbing Depth = 19 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/8/14

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

1	Counter Sinking Depth & Finish	ok								Counter = 60° Row = 32
2	External Relief Dia	4.5 n/c	outside (3-3)		Inner					
3	External Relief Depth		21 n/c		17 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									6 2 24

Inspected By (Sign) & Date

Ravi 6/8/14

6/2/14

Reviewed by (Engineer-CNC)

Manager-QA