



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.		10989	55/66
2	Machined By		V.T.L. H/C Shop	Dy. Insp. L. S. C. 29/136
3	Pallet Die No.		11768 (3.5) H/C	Rev. 2.01
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1032 H/C, Step OD = 1033 H/C	Step length = 37 H/C
6	Inside Diameter	Drg. No.	900.12 H/C	Tappers 3
7	Width of Pellet Die	Drg. No.	375 H/C	Undercut = 0.5 H/C
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 H/C / 29.5 x 8 x 13 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of Holes = 15 Both Side
12	Tapping PCD		970 H/C	
13	Tapping Hole Diameter		M24 Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 38.7 H/C	Tapping Depth = 38.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 21/8/14	2 slot 32.1 H/C width 7.5 H/C Depth Both side
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° Tap = 59°
2	External Relief Dia	4.0 H/C	Outside (4-4)	Inner
3	External Relief Depth		18 H/C	11 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Romare	
6	Material Sent For Hardening On Date		7 2 14	
Inspected By (Sign) & Date			Ravi 21/8/14	

Reviewed by (Engineer-CNC)

Manager-QA