



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.		10824	75/75
2	Machined By		V.T.L. H/C Shop	Qty Nos. 1:30 = 671
3	Pallet Die No.		11774 (8.0) mm	Rev 2.00
4	Die Category	Drg. No.	S. Jambha	
5	Out Side Diameter	Drg. No.	1061 mm, Step 00, 1041 mm	Tapper = 4°
6	Inside Diameter	Drg. No.	911.14 mm, (A)	Step length = 29 mm
7	Width of Pellet Die	Drg. No.	388 mm, (A)	
8	Grooves as per Drawing	Drg. No.	33x10x10 mm, 33x10x9.6 mm	
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 = 16 Both side
12	Tapping PCD		975 mm	
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 = 41.4 mm, Tapping Depth = 38 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 7/2/14	
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°
2	External Relief Dia	9.0 mm	outside (3-3)	Lower 30
3	External Relief Depth		8 mm	Nil
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		7 2 14	
Inspected By (Sign) & Date			Ravi 7/2/14	

Reviewed by (Engineer-CNC)

Manager-QA