



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.			
2	Machined By		11178	40/50 ✓
3	Pallet Die No.		V.T.L. n/c Shop	Drg No. L.S.O. 493
4	Die Category	Drg. No.	11207 (4.0) n/c	200200 ✓
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	700 n/c, Step OD = 693.8 n/c	① Tapped 12
7	Width of Pellet Die	Drg. No.	600.12 n/c	Step length = 2mm
8	Grooves as per Drawing	Drg. No.	222 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12410 x 7.5 n/c / 11.9 x 10 x 7.5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of holes 12 Both Side
13	Tapping Hole Diameter		640 n/c	
14	Tapping On Second Side	Half pitch of 1st side	M20 = Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 214 n/c Tapping Depth: 18.8 n/c	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 21/8/14

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°
2	External Relief Dia	4.5 n/c	Outside (2-3)	Inner			Row = 31
3	External Relief Depth		14 n/c	10 n/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Perance				
6	Material Sent For Hardening On Date		2	2	24		

Inspected By (Sign) & Date

Ravi 21/8/14

Reviewed by (Engineer-CNC)

Manager-QA