



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.		11206	36/50
2	Machined By		V.T.G. n/c Shop	Drg No. L.S.D. 670
3	Pallet Die No.		11676 (3.0) n/c	Rev. No.
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	760 n/c, Step OD: 803 n/c	Step length 30 n/c
6	Inside Diameter	Drg. No.	660.12 n/c	Taper: 10°
7	Width of Pellet Die	Drg. No.	290 n/c	Under cot 221.5 n/c
8	Grooves as per Drawing	Drg. No.	27+8+7.5 n/c / 27+8+7.5 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		734 n/c	
13	Tapping Hole Diameter		M22 - Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 30.4 n/c	Tapping Depth: 27.8 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/7/13

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 - 1 Hole. Closed (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counters 60°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	3.3 n/c	outside (3-3)		Inner					
3	External Relief Depth		20 n/c		14 n/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date									7 2 24

Inspected By (Sign) & Date

Ravi 31/7/13

Reviewed by (Engineer-CNC)

Manager-QA