



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.		11242	48/55
2	Machined By		V.T.L. H/O Shop	Drg. No. 13.02.809
3	Pallet Die No.		11434 (3.5) H/H	Rev. No.
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	710 H/H, Step OD, 703 H/H	Tappers 4"
6	Inside Diameter	Drg. No.	600.12 H/H	Step length. 38 H/H
7	Width of Pellet Die	Drg. No.	250.1 H/H	
8	Grooves as per Drawing	Drg. No.	24x5x9 H/H / 24x5x9 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	Tapping No. of holes 12 Rodu Side
12	Tapping PCD		655 H/H	
13	Tapping Hole Diameter		MIG - Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 252 H/H	Tapping Depth. 258 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 8/8/14	
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° Ravi = 37°
2	External Relief Dia	4.0 H/H	outside (3-3)	inner
3	External Relief Depth		16 H/H	9 H/H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		8	2 94
Inspected By (Sign) & Date			Ravi 8/8/14	

Reviewed by (Engineer-CNC)

Manager-QA