



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)

6933

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11249	40/50
3	Pallet Die No.		V.T.L. H/c Shop	Digital 18.0-805
4	Die Category	Drg. No.	11704 (8.0) H/c	Recess
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	5.20 H/c Step 00, 492 H/c	Step length = 17.4
7	Width of Pellet Die	Drg. No.	4.20 ± 0.12 H/c	
8	Grooves as per Drawing	Drg. No.	158 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12.78 ± 0.3 H/c 12.78 ± 0.3 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping No. of Holes 8 Both Side
13	Tapping Hole Diameter		4.54 H/c	
14	Tapping On Second Side	Half pitch of 1st side	0.34" = Check by 0.24" Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 19.8 H/c	Tapping Depth = 17.2
17	Visual Inspection Before Gun Drilling		Yes	
			ok	

Inspected By (Sign) & Date

Ravi 10/9/14

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	8.5 H/c	outside (2-2)		Innen		Row = 12
3	External Relief Depth		1.9 H/c		4 H/c		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		10	2	24		

Inspected By (Sign) & Date

Ravi 10/9/14

Reviewed by (Engineer-CNC)

Manager-QA