



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)

6979

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11282	43/50
2	Machined By		V.T.L. N/C Shop	Dr. H. S. K. C. 998
3	Pallet Die No.		11624 (4.0) mm	Rev 2.00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620.1 mm, Step 00: Tappers 12° Step length 18	
6	Inside Diameter	Drg. No.	520.12 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
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 Rote Side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 = Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 21.3 mm Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi Solanki

1 As per programme no.

2 Gun Drilling Work Completed On

3 Hole Finish In Gun Drilling

Marked

4 Defective Holes (If Any)

OK

No

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

1	Counter Sinking Depth & Finish	OK							Rev 2-31
2	External Relief Dia	4.5 mm	Outside (3-3)		Inner				
3	External Relief Depth		12 mm		8 mm				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date			20	2	24			

Inspected By (Sign) & Date

Ravi Solanki

Reviewed by (Engineer-CNC)

Manager-QA