



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11071	33/50
2	Machined By		V.T.L. H/C Shop	Dr. H. S. L. S. C. 16/78
3	Pallet Dia No.		8895 (3.0) H/C	Rev. 00
4	Die Category	Drg. No.	N7910	
5	Out Side Diameter	Drg. No.	700 H/C / Step 002 701.7 H/C	Tapper 12°
6	Inside Diameter	Drg. No.	600.12 H/C	Step length = 24 H/C
7	Width of Pellet Die	Drg. No.	265 H/C	Under cut = 0.8 H/C
8	Grooves as per Drawing	Drg. No.	15x8x7 H/C / 15x8x7 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping H/C of holes = 12 Both Side
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21 H/C	Tapping Depth = 19 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/7/13

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

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

1	Counter Sinking Depth & Finish	ok					Counters 60
2	External Relief Dia	3.5 H/C	outside (3-3)		Inner		low = 47
3	External Relief Depth		2.3 H/C		1.7 H/C		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Fornece
6	Material Sent For Hardening On Date		23	24			

Inspected By (Sign) & Date

Ravi 23/7/13

Reviewed by (Engineer-CNC)

Manager-QA