



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.		11260	40/48/55
2	Machined By		V. T. L. H/C Shop	Drilling 1.8.03
3	Pallet Die No.		11637 (A.0) H/C	Reorder
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	7.10 H/C, Step OD: 698.8 H/C	Tappers 12°
6	Inside Diameter	Drg. No.	600.12 H/C / 600.14 H/C	Step length 19.8
7	Width of Pellet Die	Drg. No.	22.2 H/C	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 7.5 H/C / 12 x 10 x 7.5 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		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 21.3 H/C	Tapping Depth: 18.8 H/C
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 22/7/14

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 6°
2	External Relief Dia	6.5 H/C / 7.0 H/C	6.5 H/C All Rows	7.0 H/C All Rows					
3	External Relief Depth		15 H/C	7 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		22	24					

Inspected By (Sign) & Date

Ravi 22/7/14

Reviewed by (Engineer-CNC)

Manager-QA