



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

2004

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.		11302	45/50
2	Machined By		V.T.L. H/C Shop	Drill dia 1.2.02 370
3	Pallet Die No.		11706 (6.0) H/C	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	52.0 H/C, Step ODs 49.1 H/C	Step lengths 19 H/C
6	Inside Diameter	Drg. No.	48.0 ± 0.12 H/C	17.5 H/C
7	Width of Pellet Die	Drg. No.	159.5 H/C	
8	Grooves as per Drawing	Drg. No.	13.5 x 8 x 3 H/C 12.4 x 8 x 3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of holes = 8 Both side
12	Tapping PCD		45.4 H/C	
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19 H/C Tapping Depth 17 H/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Pasi 26/7/14

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

Counter = 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 H/C	Outside (2-2)		Innen				
3	External Relief Depth		11 H/C		5 H/C				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		26	8	24				

Inspected By (Sign) & Date

Pasi 26/7/14

Reviewed by (Engineer-CNC)

Manager-QA