



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.		11199	33/28/66
2	Machined By		V. T. L. n/c Shop	Dry No. 13.0.2009
3	Pallet Die No.		11908 (G.O) n/c	Revol
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 n/c Step OD = 692 n/c	Tabber 8°
6	Inside Diameter	Drg. No.	548.12 n/c	Step length 3.5 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c 32 x 7 x 8 n/c (4x8)	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 8 n/c
10	Drilling Area Surface Smoothness		ok	Deep Botm Side
11	Tapping Operator		n/c Shop	Tapping No. of Holes 4
12	Tapping PCD		619 n/c	Botm Side
13	Tapping Hole Diameter		NIG = Check by NIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.4 n/c	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 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

1	Counter Sinking Depth & Finish	OK						Counter 30°
2	External Relief Dia	6.5 n/c 7.5 n/c	6.5 n/c All Rows	7.5 n/c All Rows				Revol 12
3	External Relief Depth	-	33 n/c	28 n/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		26	27	28	29		

Inspected By (Sign) & Date

Ravi 26/7/14

Reviewed by (Engineer-CNC)

Manager-QA