



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.		11394	23/33/66
2	Machined By		M.T.L. N/C Shop	Drg No. 68.0.609
3	Pallet Die No.		11923 (G.O) H4	Record
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H4	Step 00, 693 H4 Tapper 28°
6	Inside Diameter	Drg. No.	548.14 H4	Step length 2.31 H4
7	Width of Pellet Die	Drg. No.	195 H4	Under cot = 2.5 H4
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H4 / 32 x 7 x 8 H4 (4 x 8) H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	8 mm Deep Both Side
11	Tapping Operator		N/C Shop	Tapping No.
12	Tapping PCD		619 H4	of holes = 4
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.8 H4	Tapping Depth = 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 8/24*

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 = 300
2	External Relief Dia	6.5 H4 / 7.0 H4	6.5 H4	All Rows	7.0 H4	All Rows	
3	External Relief Depth		4.3 H4			3.3 H4	
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		8	4	24		

Inspected By (Sign) & Date *Ravi 8/24*

Reviewed by (Engineer-CNC) *Satish Kumar*

Manager-QA