



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)

SNo.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10000	40/55/80
2	Machined By		V.T.L n/c Shop	Dy No. 1.2.0. 859
3	Pallet Die No.		10861 (8.0) n/c	Rev. 01
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	730 n/c 732 n/c Step 00	632 n/c
6	Inside Diameter	Drg. No.	572.12 n/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	219 n/c	
8	Grooves as per Drawing	Drg. No.	67x8x8 n/c 28x8x8 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No of holes = 6
12	Tapping PCD		650 n/c	
13	Tapping Hole Diameter		NIG Check by HIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one Side Tapping and	Third Side One Slot
15	Tapping Hole Depth		Drill Depth 40.7 n/c	Tapping Depth 38.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 27/7/13

1	As per programme no.		_____	<div style="border: 1px solid black; padding: 5px;"> 1 SLOT 38.1 n/c width 19 n/c Deep [R. 36x19] Slot </div>
2	Gun Drilling Work Completed On		_____	
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		No	

will be maintained after Hardening

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

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	8.5 n/c 9.0 n/c	8.5 n/c All Lines	9.0 n/c All Lines					
3	External Relief Depth		40 n/c	25 n/c					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark For race						
6	Material Sent For Hardening On Date		27	27	28				

Inspected By (Sign) & Date

Ravi 27/7/13

Reviewed by (Engineer-CNC)

Manager-QA