



Lark Engineering Company (India) Pvt. Ltd.

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

10035

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.			
2	Machined By		15106 ✓	58/66
3	Pallet Die No.		V.T.L. H/c Shop	Drg No. 130.830
4	Die Category	Drg. No.	15215 (9.0) H/c	Rev. 08
5	Out Side Diameter	Drg. No.	N. Turn 60	
6	Inside Diameter	Drg. No.	680.1 H/c	Step 00. 393 H/c
7	Width of Pellet Die	Drg. No.	546.12 H/c (Bore 548.2 H/c)	Step length 31 H/c
8	Grooves as per Drawing	Drg. No.	195 H/c	Under cut 2.8 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	327.7 x 9.1 H/c 327.7 x 9.1 H/c	(4 x 8) H/c
10	Drilling Area Surface Smoothness		ok	Face Side
11	Tapping Operator		ok	Step 2 H/c
12	Tapping PCD		H/c Shop	Back Side
13	Tapping Hole Diameter		619 H/c	Tapping H/c
14	Tapping On Second Side	Half pitch of 1st side	H16, Check by H16 Bolt	of H/c 2
15	Tapping Hole Depth		ok	Back Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.6 H/c	Tapping Depth 31.6 H/c
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

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 80
2	External Relief Dia	10.0 H/c	[11 Rows]					Row 8
3	External Relief Depth		8 H/c					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Ferrare					
6	Material Sent For Hardening On Date		7	6	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA