



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.		15901	4d55
2	Machined By		V.T.L. n/c Shop	Dyn. L.E.C.N 934
3	Pallet Die No.		16321(8.0) n/c	Rev. 99
4	Die Category	Drg. No.	2nd side	
5	Out Side Diameter	Drg. No.	629.9 mm	Step 11.9 mm
6	Inside Diameter	Drg. No.	520.14 mm	Step length 19.5
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		56.5 mm	
14	Tapping On Second Side	Half pitch of 1st side	1200 Clock by 120 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 mm	Tapping Depth 18.4
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							
2	External Relief Dia	8.5 mm	23-31		Inner				
3	External Relief Depth	23 mm			15 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date

--	--	--	--	--	--	--	--	--	--

Reviewed by (Engineer-CNC)

Manager-QA