



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.		11987	38/50
2	Machined By		N.T.L. n/c Shop	Drg No. 1202978
3	Pallet Die No.		12916 (G.O) n/c	Reverse
4	Die Category	Drg. No.	582	
5	Out Side Diameter	Drg. No.	520 n/c	Step OD = 491 n/c / 497 Step length = 19.5
6	Inside Diameter	Drg. No.	420.14 n/c	
7	Width of Pellet Die	Drg. No.	182 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c / 12x8x3 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 = 8
12	Tapping PCD		454 n/c	Both Side
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 n/c	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 17/7/12

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 = 60
2	External Relief Dia	Ø.5 n/c	Outside (2-2)	Inner				Rav. 18
3	External Relief Depth		2mm	12 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		17	7	24			

Inspected By (Sign) & Date

Ravi 17/7/12

Reviewed by (Engineer-CNC)
Soty 17/7/12

Manager-QA