



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		12882	35/40/495
2	Machined By		V. T. L. H/O Shop	Dry hole 2.5mm
3	Pallet Die No.		11328 (3-2mm)	Re-use
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm Shop 022 491	Step length 2.5
6	Inside Diameter	Drg. No.	420.12mm	
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
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 Re-use
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		N/C = Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 18.4mm	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 24/8/13

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	3.5mm	possible (2-2)	inner				
3	External Relief Depth		1mm	5mm				
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

Ravi 24/8/13

Reviewed by (Engineer-CNC)
Sati 24/8/13

Manager-QA