

Lark Engineering Company (India) Pvt. Ltd.

111 Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12/13	72/50
2	Machined By		VTL M/C S/OP	Drg No - IEC 9930
3	Pallet Die No.		19837 (4.0mm)	(REV00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	60mm	Step length - 18.5mm
6	Inside Diameter	Drg. No.	50-19mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	[Tapping No. of Holes 12 Both Side]
11	Tapping Operator		M/C S/OP	
12	Tapping PCD		56.5mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 17/08/14

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

Counter - 60°

1	Counter Sinking Depth & Finish	OK							Row - 31
2	External Relief Dia	4.5mm	outside C3-C3	Inner					
3	External Relief Depth		19mm	8mm					
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		17	08	14				

Inspected By (Sign) & Date

Ramanpreet Singh 17/08/14

[Signature]
17/08/14

Reviewed by (Engineer-CNC)

Manager-QA