



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.			
2	Machined By		13008	32/55
3	Pallet Die No.		V. T.L. H/c Shop	Dwg No. 49.029.03
4	Die Category	Drg. No.	12225(3.0)H	Rev. 00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	530H Step 00. 498	88H Tapped 12
7	Width of Pellet Die	Drg. No.	420.12H	Step length 18H
8	Grooves as per Drawing	Drg. No.	158H	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3H 12x8x3H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping H/c of holes 8 Beta Side
13	Tapping Hole Diameter		454H	
14	Tapping On Second Side	Half pitch of 1st side	H22 Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 18.4H Tapping Depth 16.5	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 21/10/14

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

1	Counter Sinking Depth & Finish	ok						Counter = 60
2	External Relief Dia	3.5H	outside (2-2)		Inner			Rev: 24
3	External Relief Depth		29H		23H			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Ramesh
6	Material Sent For Hardening On Date		21	10	24			

Inspected By (Sign) & Date

Ravi 21/10/14

Reviewed by (Engineer-CNC)

Manager-QA