



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.		13135 ✓	45/60 ✓
2	Machined By		V. T. L. N. C. Shop	Dry No. 13.02 174
3	Pallet Die No.		12858(80)M ✓	Rev 200 ✓
4	Die Category	Drg. No.	H. Jomba	
5	Out Side Diameter	Drg. No.	720M ✓ Step 00.692M ✓	Tabber 12°
6	Inside Diameter	Drg. No.	600.12M ✓	Step length 20M ✓
7	Width of Pellet Die	Drg. No.	222M ✓	
8	Grooves as per Drawing	Drg. No.	12x8x5M ✓ 12x8x5M ✓	
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 = 12 Both Side
12	Tapping PCD		640M ✓	
13	Tapping Hole Diameter		M2-2 Check by M2 Bit	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4M ✓ Tapping Depth 21.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 11/11/12

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

Counter 60°
Low 218

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	8.5M ✓	Outside (3-3)	Inner			
3	External Relief Depth		23M ✓	15M ✓			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Machine				
6	Material Sent For Hardening On Date		"	"	24		

Inspected By (Sign) & Date

Ravi 11/11/12

Reviewed by (Engineer-CNC)

Manager-QA