



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

8697

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		13448	4/12/2014
3	Pallet Die No.		V. 7.6 u/c Step	By the last
4	Die Category	Drq. No.	9176(40)u/c	
5	Out Side Diameter	Drq. No.	52370	
6	Inside Diameter	Drq. No.	62 u/c Step 00. 612 u/c Step length 194	
7	Width of Pellet Die	Drq. No.	520.12 u/c	
8	Grooves as per Drawing	Drq. No.	186 u/c	
9	Fitting Sizes on CNC Plate	Drq. No.	13x8x5 u/c 12x8x5 u/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		u/c Step	Tapping Holes of 1st side of both sides
13	Tapping Hole Diameter		56.5 u/c	
14	Tapping On Second Side	Half pitch of 1st side	H20 - Crack by H20 Ball	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 u/c Tapping Depth 18.6	
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

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	4.5 u/c	Outside 20-25		Inner				
3	External Relief Depth		10 u/c		2 u/c				
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

Reviewed by (Engineer-CNC) *Sahar* 4/12/14
 Manager-QA *Ravi* 4/12/14