



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13704	40/50
2	Machined By		V.T.L. H/C Shop	6355
3	Pallet Die No.		13686(3.2)H	10
4	Die Category	Dr. No.	Outside	
5	Out Side Diameter	Dr. No.	620H	
6	Inside Diameter	Dr. No.	Step 00, 612H	Step length 19.5
7	Width of Pellet Die	Dr. No.	520.12H	
8	Grooves as per Drawing	Dr. No.	222H	
9	Fitting Sizes on CNC Plate	Dr. No.	13x8x5H 13x8x5H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565H	Tapping No. of Holes: 12 Both Side
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 20.3H	Tapping Depth 18.5H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 26/12/14	
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 - 1 Hole Closed	
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	3.8H	Outside (3-3)	10237
3	External Relief Depth		16H	10H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		26	12
Inspected By (Sign) & Date			Ravi 26/12/14	

Reviewed by (Engineer-CNC)

Manager-QA