



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.		13753 ✓	45/50/8355
2	Machined By		V.T.L n/c Shop	Dy. Mr. Lal 8310
3	Pallet Die No.		13693 (6.0) ✓	
4	Die Category	Drg. No.	Ex-bar side	
5	Out Side Diameter	Drg. No.	62mm, Step 00, 612mm	Step length 19.5
6	Inside Diameter	Drg. No.	520.12mm ✓	
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	
11	Tapping Operator		n/c Shop	Tapping of Holes 12 Both Side
12	Tapping PCD		565mm ✓	
13	Tapping Hole Diameter		42mm. Check by H2 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.2mm	Tapping Depth: 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 11/12/15

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° Ravi 23
2	External Relief Dia	6.5mm ✓	Outside (2-3)		Inner				
3	External Relief Depth		11mm ✓		5mm ✓				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date								1 1 25

Inspected By (Sign) & Date

Ravi 11/12/15

Reviewed by (Engineer-CNC)

Manager-QA