



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.		13721 ✓	36/50 ✓
2	Machined By		V. T. L. H/C Shop	Drg. No. L.E.C. 12814
3	Pallet Die No.		12015 (3.0) H/C	Rev. 00 ✓
4	Die Category	Drg. No.	M740	
5	Out Side Diameter	Drg. No.	700 H/C Step OD = 692 H/C	Step length = 9.5
6	Inside Diameter	Drg. No.	600.12 H/C	
7	Width of Pellet Die	Drg. No.	265 H/C	
8	Grooves as per Drawing	Drg. No.	15x8x7 H/C / 15x8x7 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		640 H/C ✓	
13	Tapping Hole Diameter		M2 = Check by M20 Ball ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.2 H/C Tapping Depth = 18.5 H/C	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 21/125	
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 47
2	External Relief Dia	3.5 H/C	Outside (3-3)	Inner
3	External Relief Depth	/	20 H/C	14 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Forge	
6	Material Sent For Hardening On Date		2	1 25
Inspected By (Sign) & Date			Ravi 21/125	

Reviewed by (Engineer-CNC)

Manager-QA