



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.		13719	45/52
2	Machined By		V.T.L. n/c. Shop	Drg No. 13.D. 1112
3	Pallet Die No.		1987(8.0) n/c	Rev. 2.00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	734.0 n/c / Step on 733.3 n/c	Tapped 12°
6	Inside Diameter	Drg. No.	630.12 n/c	Step length 23 n/c
7	Width of Pellet Die	Drg. No.	250 n/c	
8	Grooves as per Drawing	Drg. No.	17x8x7 n/c / 17x8x7 n/c	
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		680 n/c	
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 25.2 n/c	Tapping Depth 28.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/7/13

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	8.5 n/c	Outside (3-3)		Inner					
3	External Relief Depth		15 n/c		7 n/c					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Formace
6	Material Sent For Hardening On Date			3	1	25				

Inspected By (Sign) & Date

Ravi 31/7/13

Reviewed by (Engineer-CNC)

Manager-QA