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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.		13778 ✓	35/40
2	Machined By		V.T.L. H/c Shop	Dy. Mgr. Lark
3	Pallet Die No.		12719 (5.0) ✓	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c ✓	Step length 175
6	Inside Diameter	Drg. No.	420.12 H/c ✓	
7	Width of Pellet Die	Drg. No.	158 H/c ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c ✓	Tapping H/c of holes 8 Rote Side
13	Tapping Hole Diameter		M 20 + Check by M 20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.2 H/c ✓	Tapping Depth 6.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/125

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 Sink By Ravi 31/125
2	External Relief Dia	53 H/c ✓	outside (2-2)		Inner				
3	External Relief Depth		10 H/c ✓		5 H/c ✓				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Porrace
6	Material Sent For Hardening On Date			3	1	25			

Inspected By (Sign) & Date

Ravi 31/125

Reviewed by (Engineer-CNC)
 Ravi 31/125

Manager-QA