



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.		14086 ✓	32/50 ✓
2	Machined By		V.T.L H/C Shop	Dry No. 1.8.2.998
3	Pallet Die No.		13725(3.0) H/C	Rev. 00
4	Die Category	Drg. No.	Extr. die	
5	Out Side Diameter	Drg. No.	619.8 H/C Step 00.2 Tapper. 12"	
6	Inside Diameter	Drg. No.	520.12 H/C (Boss Tapper. 0.3 H/C) Step length 18.5 H/C	
7	Width of Pellet Die	Drg. No.	222 H/C ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C / 13x8x5 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		565 H/C ✓	
13	Tapping Hole Diameter		M20.2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 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 31/12/13

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							Count on 60
2	External Relief Dia	3.5 H/C	outside (3-3)		Inner				Rev. 38
3	External Relief Depth		18 H/C ✓		18 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		31	1	25				

Inspected By (Sign) & Date

Ravi 31/12/13

Satyam 31/12/13

Reviewed by (Engineer-CNC)

Manager-QA