



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.		14302	42/50
2	Machined By		V.T.L. N/C Shop	6355 Dy. S. Lark
3	Pallet Die No.		14178 (3.2) H-1	
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	62 H-1, Step 002 611.9 H-1	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H-1	
7	Width of Pellet Die	Drg. No.	222 H-1	
8	Grooves as per Drawing	Drg. No.	13x8x5 H-1 13x8x5 H-1	
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		565 H-1	
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 20.3 H-1 Tapping Depth 18.0 H-1	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/7/13

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	3.8 H-1	Outside (3-3)		Inner				
3	External Relief Depth		15 H-1		8 H-1				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date			21	2	25			

Inspected By (Sign) & Date

Ravi 21/7/13

Reviewed by (Engineer-CNC)

Manager-QA