



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.		1419d ✓	33/50
2	Machined By		V.T.L H/c Shop	Drg. No. 1.3.2.450
3	Pallet Die No.		13165 (3.0) H/c	Rev. 00 ✓
4	Die Category	Drg. No.	J&D	
5	Out Side Diameter	Drg. No.	730 H/c, Step OD, 743.4 H/c	Tapped 50°
6	Inside Diameter	Drg. No.	630.12 H/c	Step length 23 H/c
7	Width of Pellet Die	Drg. No.	290 H/c ✓	Under cut = 6.75 ✓
8	Grooves as per Drawing	Drg. No.	15x8x5 H/c / 15x8x5 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 = 16 Both Side
12	Tapping PCD		685 H/c ✓	
13	Tapping Hole Diameter		H/c ✓ Check by H/c 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 21/2/13

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

Counter Bo

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	3.5 H/c	outside (3.3)		inner					
3	External Relief Depth		23 H/c		17 H/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date									

Inspected By (Sign) & Date

Ravi 21/2/13

Reviewed by (Engineer-CNC)

Manager-QA