



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)

9272

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14208 ✓	30/40
2	Machined By		V.T.C. H/c Shop	Drg. No. 13201
3	Pallet Die No.		13201 (3.0) H/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	40mm Step 001 395mm	Step length 14.5
6	Inside Diameter	Drg. No.	320.12 mm	
7	Width of Pellet Die	Drg. No.	142 mm	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 mm 15.5 x 7 x 2 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		355 mm	Tapping No. of Holes 8 Both Side
13	Tapping Hole Diameter		H/c Check by H/c Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.3mm Tapping Depth: 18.6mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi: 24/2/15

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: 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5 mm	Outside (2-2)		Inner				
3	External Relief Depth		13 mm		10 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		24	2	25				

Inspected By (Sign) & Date

Ravi: 24/2/15

24/2/15

Reviewed by (Engineer-CNC)

Manager-QA