



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.		137#9	36/45
2	Machined By		V.T.L n/c stop	Dry No. 1-30-1145
3	Pallet Die No.		14162 (6.0) n/c	Rev. no
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	407.8 n/c Step 00. 388.8 n/c	Step length 0.5
6	Inside Diameter	Drg. No.	318.12 n/c	
7	Width of Pellet Die	Drg. No.	134 n/c	
8	Grooves as per Drawing	Drg. No.	8x5x3 n/c 8x5x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c stop	Tapping No. of holes = 8 Both Side
12	Tapping PCD		349 n/c	
13	Tapping Hole Diameter		0.12" = Check by 0.12" Tap	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 15.4 n/c Tapping Depth 13.5 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/7/13

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						Counter Go
2	External Relief Dia	6.5 n/c	outside (2-2)		inner			Rev = 14
3	External Relief Depth		15 n/c		9 n/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark furnace
6	Material Sent For Hardening On Date		28	2	25			

Inspected By (Sign) & Date

Ravi 28/7/13

Satish 28/7/13

Reviewed by (Engineer-CNC)

Manager-QA