



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.		14549	40/55
2	Machined By		V.T.L. N/C Shop	Qty 10, 12.5 = 355
3	Pallet Die No.		13606 (8.0) H	Rev. 100
4	Die Category	Drg. No.	SS870	
5	Out Side Diameter	Drg. No.	689.9 H, Step 00, 612 H	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H	
7	Width of Pellet Die	Drg. No.	186 H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H / 12x8x3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping N/C of holes 12
12	Tapping PCD		565 H	Body Side
13	Tapping Hole Diameter		H20, Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.2 H	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi: 24/25	
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 Sink
2	External Relief Dia	8.5 H	All Rows	Row = 14
3	External Relief Depth		15 H	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		2 4 25	
Inspected By (Sign) & Date			Ravi: 24/25	

Reviewed by (Engineer-CNC)

Manager-QA