



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.		14580	34/45
2	Machined By		V.T.L. H/c Shop	Dr. H/c 12.0.81
3	Pallet Die No.		14479 (2.8) H/c	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	610 H/c	Step 00.2 621.4 H/c
6	Inside Diameter	Drg. No.	520.12 H/c	Tab. H/c 12
7	Width of Pellet Die	Drg. No.	222 H/c	Step length 21.1
8	Grooves as per Drawing	Drg. No.	222 H/c	Under cut 5.25
9	Fitting Sizes on CNC Plate	Drg. No.	1348x5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c	Tabbing H/c of holes 12
13	Tapping Hole Diameter		H/c 22 Check by H/c 20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 H/c	Tabbing Depth 18
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

Counter 60

1	Counter Sinking Depth & Finish	ok								Rev 239
2	External Relief Dia	3.1 H/c								
3	External Relief Depth									
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 24/25

Reviewed by (Engineer-CNC)

Manager-QA