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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.		14674	33/38
2	Machined By		V.T.L. M/C Shop	Qty 12.02.10
3	Pallet Die No.		14375 (3.0) M	Renew
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	676 M, Step on 703 M	Tapping 4
6	Inside Diameter	Drg. No.	600.12 M	Step length 23.5
7	Width of Pellet Die	Drg. No.	250 M	Width 13.5
8	Grooves as per Drawing	Drg. No.	24 x 5 x 9 M / 24 x 5 x 9 M	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	Tapping M
12	Tapping PCD		655 M	of holes 12
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 24.3 M	Tapping Depth 22.6 M
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sasi 12/07/15	
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				
1	Counter Sinking Depth & Finish	OK		Counter 41
2	External Relief Dia	3.5 M	Outside 23-3	Inner
3	External Relief Depth		11 M	5 M
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Remach	
6	Material Sent For Hardening On Date		10 4 25	
Inspected By (Sign) & Date			Sasi 12/07/15	

Reviewed by (Engineer-CNC)

Manager-QA