



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.		14548	38/48/60
2	Machined By		N.T.L. n/c Shop	Dyn. L.S.D. 654
3	Pallet Die No.		14152 (6.0) n/c	Rev. n/c
4	Die Category	Drg. No.	N. 70 n/c	
5	Out Side Diameter	Drg. No.	7.2 n/c, Step n/c, 8.92 n/c	Step length 19.5
6	Inside Diameter	Drg. No.	6.00.12 n/c	
7	Width of Pellet Die	Drg. No.	2.22 n/c	
8	Grooves as per Drawing	Drg. No.	36 x 10 x 7 n/c 36 x 10 x 7 n/c	
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 Both Side
12	Tapping PCD		645 n/c	
13	Tapping Hole Diameter		n/c 2. Check by N20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 17/4/15

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						Raw: 16
2	External Relief Dia	6.5 n/c, 11 n/c	6.5 n/c	11 Rows	2.22 n/c			
3	External Relief Depth		1.0 n/c	11 Rows	1.8 n/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		17	4	25			

Inspected By (Sign) & Date

Raw: 17/4/15

Reviewed by (Engineer-CNC)

Manager-QA