



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)

9711

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14786	36145150
2	Machined By		V.T.L. n/c Shop	Drg. No. 13.22859
3	Pallet Die No.		13849 (40) n/c	Rev. No.
4	Die Category	Drg. No.	Extrusion die	
5	Out Side Diameter	Drg. No.	620 n/c Shop OD: 624 n/c	Tapping: 12
6	Inside Diameter	Drg. No.	520.12 n/c	Step length: 18 n/c
7	Width of Pellet Die	Drg. No.	228 n/c	Undercut: 1.9 n/c
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/c	
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: 20.4 n/c Tapping Depth: 18.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

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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 - 3 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter: 60
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1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5 n/c 5.0 n/c	4.5 n/c	All Rows 2 14 n/c			
3	External Relief Depth		5.0 n/c	All Rows 2 5 n/c			
4	Inspection Done Before Hardening By (Name)			Rev:			
5	Material Sent For Hardening By (Name)			Lark Purvane			
6	Material Sent For Hardening On Date		24	4	25		

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA