



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)

9749

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14672	30/50
2	Machined By		V.T.L. H/C Shop	Drilling Holes 12.0.45
3	Pallet Die No.		15220 (3.0) H/C	Ream 20
4	Die Category	Drg. No.	J20	
5	Out Side Diameter	Drg. No.	730 H/C	Step 00. 743.5 H/C Tapping 10
6	Inside Diameter	Drg. No.	630.12 H/C	Step length 83 H/C
7	Width of Pellet Die	Drg. No.	220 H/C	Under cut 6.75 H/C
8	Grooves as per Drawing	Drg. No.	15x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping Holes 16
12	Tapping PCD		685 H/C	Both Side
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 H/C	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sasi 28/4/15

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 Bo

1	Counter Sinking Depth & Finish	OK								Ream 52
2	External Relief Dia	3.5 H/C	20 H/C	23-3	Inner					
3	External Relief Depth	✓	23 H/C		20 H/C					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		28	4	25					

Inspected By (Sign) & Date

Sasi 28/4/15

Reviewed by (Engineer-CNC)

Manager-QA