



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.		14794	28/4/15
2	Machined By		V.T.C. n/c Shop	Dry H. 1.2.0.407
3	Pallet Die No.		14235(4.0) n/c	Ren 200
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	709.8 n/c Step 02: 693 n/c	Tabber 12
6	Inside Diameter	Drg. No.	600.12 n/c	Step length 12 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12-8x7 n/c / 12-8x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping H. of Holes 12 Both Side
12	Tapping PCD		640 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

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

Counter 60

1	Counter Sinking Depth & Finish	OK								Rev: 32
2	External Relief Dia	4.6mm/5.0mm	4.6mm	All Rows 2 28mm						
3	External Relief Depth		5.0mm	All Rows 2 15mm						
4	Inspection Done Before Hardening By (Name)			Rev:						
5	Material Sent For Hardening By (Name)			Lark Furnace						
6	Material Sent For Hardening On Date		28	4	25					

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA