



Lark Engineering Company (India) Pvt. Ltd.

L.T.L. Basouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

9990

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14852	Lot 50
2	Machined By		V. T. L. n/c Shop	Dyn. 1.20.14.25
3	Pellet Die No.		14597 (4.0) n/c	Rev. 02
4	Die Category	Drg. No.	H780	
5	Out Side Diameter	Drg. No.	100.8 mm, Step, 00. Tapper, 12°	
6	Inside Diameter	Drg. No.	80.0 mm	Step length 17.1
7	Width of Pellet Die	Drg. No.	265 mm	
8	Grooves as per Drawing	Drg. No.	15x8x7 mm / 15x8x7 mm	Face Side 9.1
9	Fitting Sizes on CNC Plate	Drg. No.	ok	0.8 mm Gap
10	Drilling Area Surface Smoothness		ok	Both Side
11	Tapping Operator		n/c Shop	Tapping n/c
12	Tapping PCD		640 mm	of holes - 10
13	Tapping Hole Diameter		12 mm, Check by 12 mm Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth - 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 29/4/15

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

1	Counter Sinking Depth & Finish	ok							Rev. 39
2	External Relief Dia	4.5 mm	Outside (2-3)		Inner				
3	External Relief Depth		14 mm		10 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		29	4	25				

Inspected By (Sign) & Date

Ravi 29/4/15

Reviewed by (Engineer-CNC)

Manager-QA