



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)

Remarks

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14825	50/50
2	Machined By		V.T.I. H/c Shop	Drg. No. 1.2.0-1378
3	Pallet Die No.		15110 (8.0) H/c	Rev. 01
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.9 H/c	Step 02, 491. H/c
6	Inside Diameter	Drg. No.	420.12 H/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 18.4 H/c	Tapping Depth 16
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/25

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

Count ex. G.
Row. 12

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	8.3 H/c	Outside (2.2)		Inner		
3	External Relief Depth		4 H/c		Mill		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Porridge		
6	Material Sent For Hardening On Date				5 25		

Inspected By (Sign) & Date

Ravi 15/25

Satish 15/25

Reviewed by (Engineer-CNC)

Manager-QA