



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.			
2	Machined By		14819 ✓	40/45 ✓
3	Pallet Die No.		V.T.L. H/C Shop	Dy. H. 13.2.2 ✓
4	Die Category	Drg. No.	14362 (8.0) H ✓	Rev 04
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	4.00 H ✓	Step length 10.5
7	Width of Pellet Die	Drg. No.	310.12 H ✓	
8	Grooves as per Drawing	Drg. No.	134 H ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	8 x 7 x 3 H ✓	
10	Drilling Area Surface Smoothness		8 x 7 x 3 H ✓	
11	Tapping Operator		ok	
12	Tapping PCD		ok	
13	Tapping Hole Diameter		1/2" 2 Crack by 1/2" Tap	Tabbing H. of holes 8 Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		12.11 Depth 17.2 H ✓	Tabbing Depth 15 H ✓
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

1	Counter Sinking Depth & Finish	ok						Counter 60
2	External Relief Dia	8.5 H ✓	OK Side (2.2)		Inner			Rev 2.0
3	External Relief Depth		10 H ✓		5 H ✓			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date			2	5	25		

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA