



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.		14936	40/40 9195
2	Machined By		V. T. L. H/c Shop	Dy. M. Lark 3610
3	Pallet Die No.		13987 (3.5) H	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H Step 00. 491 H	Step length 17.0
6	Inside Diameter	Drg. No.	420.14 H	
7	Width of Pellet Die	Drg. No.	158 H	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H 12 x 8 x 3 H	
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	
13	Tapping Hole Diameter		H20. Check by H20 Ball	Tapping No of Holes 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 H	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 12/5/15	
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		Counter Sink Rep: 22
2	External Relief Dia	4.0 H	Outside 2.25	Inner Mill
3	External Relief Depth		4 H	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		12 5 25	
Inspected By (Sign) & Date			Ravi 12/5/15	

Reviewed by (Engineer-CNC)

Manager-QA