



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9902

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.		14805	57/57
2	Machined By		V. T. L. n/c Shop	Dy H. 12.9.1202
3	Pallet Die No.		14373 (2.2) n/c	Rev. 00
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	644 n/c	Step OD 682 n/c
6	Inside Diameter	Drg. No.	530.14 n/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	278 n/c	
8	Grooves as per Drawing	Drg. No.	43x8x8 n/c 27x8x8 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping no. of holes 8
12	Tapping PCD		594 n/c	
13	Tapping Hole Diameter		M16, Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and other side one	
15	Tapping Hole Depth		Drill Depth 25.4 n/c	Tapping Depth 93
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.			1 Slot
2	Gun Drilling Work Completed On			29.1 n/c width
3	Hole Finish In Gun Drilling	Marked	ok	18 n/c Deep
4	Defective Holes (If Any)		No - 4 hole Closed	

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

1	Counter Sinking Depth & Finish	ok						Counter 2
2	External Relief Dia							Rev. 28
3	External Relief Depth							
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		20	5	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA