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Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		15058	31/5
2	Machined By		V.T.L. HLC Shop	Dr. No. 12.0.276
3	Pallet Die No.		13138(2.8)H	Rev. sl
4	Die Category	Drg. No.	SSS-10	
5	Out Side Diameter	Drg. No.	620mm Step 002 622.5mm	Tabber 12
6	Inside Diameter	Drg. No.	520.14mm	Step length 2mm
7	Width of Pellet Die	Drg. No.	188mm	Outer cut 1.25mm
8	Grooves as per Drawing	Drg. No.	13x8x3mm / 13x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		HLC Shop	Tapping H
12	Tapping PCD		565mm	of holes 2 12
13	Tapping Hole Diameter		420 Check by H2 Roll	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18
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 - 3 Hole Colused

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

Counter 26

1	Counter Sinking Depth & Finish	ok							Rev: 31
2	External Relief Dia	3.3mm	Outside (3.3)		Inner				
3	External Relief Depth		25mm		19mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		21	5	25				

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA