



Lark Engineering Company (India) Pvt. Ltd.

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

10036

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.		15054	50/50
2	Machined By		V.T.L. H/C Shop	12.0.453
3	Pallet Die No.		15467 (U.O) H/C	Rev: 01
4	Die Category	Drg. No.	740	
5	Out Side Diameter	Drg. No.	740 H/C	Step 00. 740.3 H/C
6	Inside Diameter	Drg. No.	630.12 H/C	Step length 83 H/C
7	Width of Pellet Die	Drg. No.	290 H/C	Order cut. 1.65 H/C
8	Grooves as per Drawing	Drg. No.	15 x 8 x 5 H/C	Face Side
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Back Side
10	Drilling Area Surface Smoothness		ok	Both Side
11	Tapping Operator		H/C Shop	Tapping H/C
12	Tapping PCD		68.5 H/C	of Holes. 16
13	Tapping Hole Diameter		H20. Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.4 H/C	Tapping Depth. 18.5 H/C
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

1	As per programme no.		Raw: 16/25	Face Side
2	Gun Drilling Work Completed On			Groove 0.8 H/C
3	Hole Finish In Gun Drilling	Marked	ok	12.0.453
4	Defective Holes (If Any)		No	Rev: 01

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

1	Counter Sinking Depth & Finish	ok						Counters 80°
2	External Relief Dia	4.5 H/C	Outside 23-33		Inner			Raw: 43
3	External Relief Depth		13 H/C		5 H/C			
4	Inspection Done Before Hardening By (Name)		Raw:					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		7	6	25			
Inspected By (Sign) & Date			Raw: 16/25					

Reviewed by (Engineer-CNC)

Manager-QA