



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.		15076	40/50
2	Machined By		V. T. L. H/c Shop	Drg No. 13.02.045
3	Pallet Die No.		14414(4.0) H/c	Rev. 01
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/c Step on G93	Tapping 12"
6	Inside Diameter	Drg. No.	600.14 H/c	Step length 20"
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	14x8x7 H/c / 14x8x7 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of holes 12-12
12	Tapping PCD		640 H/c	Both Side
13	Tapping Hole Diameter		H20 - Check by H20 B.1	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 22.4 H/c Tapping Depth. 20.6 H/c	
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

Counter = 60

1	Counter Sinking Depth & Finish	ok						Rev: 31
2	External Relief Dia	4.5 H/c	outside (3-3)		Inner			
3	External Relief Depth		14 H/c		10 H/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		4	6	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA