



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.		Tw to 15120	
2	Machined By		OK. U76- MLC Shap	32/80
3	Pallet Die No.		14612 (3-5) mm	Long H- 9980 Rao
4	Die Category	Drg. No.	SSFW	
5	Out Side Diameter	Drg. No.	620 mm	Step length - 18.5
6	Inside Diameter	Drg. No.	520 mm	Tapping 12°
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping Mo af
10	Drilling Area Surface Smoothness		OK	Holes - 12
11	Tapping Operator		MLC Shap	Both side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 Check M20 Belt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 20.4 mm Tapping Depth - 18.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

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					
2	External Relief Dia	Ø 4.0	outside	4MMEP			
3	External Relief Depth	21 mm	(3-3)	18 mm	ALL		
4	Inspection Done Before Hardening By (Name)		Sanjay				
5	Material Sent For Hardening By (Name)		hark	permy			
6	Material Sent For Hardening On Date		12	6	25		

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA