



Lark Engineering Company (India) Pvt. Ltd.

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

10054

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.			
2	Machined By		15182	53/55
3	Pallet Die No.		N.T.L. n/c Shop	Qty n. 12.0.68-
4	Die Category	Drg. No.	14383(3.8) n/c	Rev. 00
5	Out Side Diameter	Drg. No.	320	
6	Inside Diameter	Drg. No.	529.9 n/c, Step 0.2, 490.8 n/c	Step length 17
7	Width of Pellet Die	Drg. No.	420.14 n/c	
8	Grooves as per Drawing	Drg. No.	182 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	10x10x5 n/c 10x10x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		455 n/c	
14	Tapping On Second Side	Half pitch of 1st side	0.3/4" 2 Check by 0.3/4" Ball	Tapping n. of holes 8 Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 19.4 n/c	Tapping Depth 17.4
17	Visual Inspection Before Gun Drilling		yes	
			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)		n/c	

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

1	Counter Sinking Depth & Finish	ok						Counter 6"
2	External Relief Dia	4.3 n/c	Outside 22.25		Inner			For 20
3	External Relief Depth		9 n/c		2 n/c			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date		10	6	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA