



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.		15189	45/60 -
2	Machined By		V.T.L. M/c Shop	Drg No. 120.13.13
3	Pallet Die No.		15756 (8.0) M/c	Rev. 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 M/c	Step on 798 M/c
6	Inside Diameter	Drg. No.	660.14 M/c	Step length 25.5
7	Width of Pellet Die	Drg. No.	324 M/c	Under cut, 9 mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 7 M/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		725 M/c	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 30.4 M/c	Tapping Depth 28.5
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

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	8.5 M/c	23-3f		Inner				
3	External Relief Depth		23 M/c		15 M/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		16	6	25				

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA