



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.		15139	98/4-1
2	Machined By		V. T. L. H/c Shop	8195
3	Pallet Die No.		14528(3.2) H/c	98/4-1
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c	Step 002 490.9 H/c
6	Inside Diameter	Drg. No.	420.14 H/c	Step length 7.5
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		H20 = Check by H20 Belt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 H/c	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Rev: 19/6/15	
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 - 1 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		
2	External Relief Dia	3.8 H/c	Outside 2.2	Inner
3	External Relief Depth		15 H/c	12 H/c
4	Inspection Done Before Hardening By (Name)		Rev:	
5	Material Sent For Hardening By (Name)		Lark Durgam	
6	Material Sent For Hardening On Date		19 6 25	
Inspected By (Sign) & Date			Rev: 19/6/15	

Reviewed by (Engineer-CNC)

Manager-QA