



Lark Engineering Company (India) Pvt. Ltd.

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

10128

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.		14725	3015
2	Machined By		V. T. L. H/C Shop	Depth 13.25
3	Pallet Die No.		15221 (4.0)mm	Reverse
4	Die Category	Drg. No.	J&D	
5	Out Side Diameter	Drg. No.	730mm Step 80. 743mm	Tapping
6	Inside Diameter	Drg. No.	630.14mm	Step length 23mm
7	Width of Pellet Die	Drg. No.	290mm	Undercut 6.7mm
8	Grooves as per Drawing	Drg. No.	15x8x5mm / 15x8x5mm	Face Side Step
9	Fitting Sizes on CNC Plate	Drg. No.	ok	0.8mm Depth
10	Drilling Area Surface Smoothness		ok	Both Side
11	Tapping Operator		H/C Shop	Tapping
12	Tapping PCD		685mm	of Holes 16
13	Tapping Hole Diameter		42mm Check by H2 B.11	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.5
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

Count on 21
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1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.5mm	outside 23-35	inner				
3	External Relief Depth		18mm	14mm				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		21	6	25			

Inspected By (Sign) & Date

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Manager-QA

Reviewed by (Engineer-CNC)