



Lark Engineering Company (India) Pvt. Ltd.

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

10127

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		14976	30/65
3	Pallet Die No.		V. 7.1.1 H/c Shop	(Dry H. 12.0.951)
4	Die Category	Drg. No.	15815(4.5)H	Rev. 00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	550 H, Step 00. 491 H	Step length 7.5
7	Width of Pellet Die	Drg. No.	420.12 H	492 H
8	Grooves as per Drawing	Drg. No.	158 H	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H	12x8x3 H
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		454 H	
14	Tapping On Second Side	Half pitch of 1st side	H2 = Check by H2 Ball	Tapping H. of hole. 8 Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 19 H	Tapping Depth 17 H
17	Visual Inspection Before Gun Drilling		Yes	

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							Counter B.
2	External Relief Dia	5.0 MM	OUTSIDE		Inner				Rev. 18
3	External Relief Depth		14 H		5 H				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date

21/6/13

Rev: 21/6/13

Reviewed by (Engineer-CNC)

Manager-QA