



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.		15161	40/60
2	Machined By		V.T.L. H/C Shop	By 18.07.13
3	Pallet Die No.		14915 (8.0) H/C	Rev 2 on
4	Die Category	Drg. No.	H. 10mm 20	
5	Out Side Diameter	Drg. No.	719.9 H/C Step 002 692.8 H/C	Tapping 18.07.13
6	Inside Diameter	Drg. No.	600.14 H/C	Step length 18.07.13
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	12710 x 7.5 H/C / 12710 x 7.5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping 18.07.13
12	Tapping PCD		640 H/C	of holes 18.07.13
13	Tapping Hole Diameter		120.2 Check by 120.2 B/L	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 220.6 H/C	Tapping Depth 18.07.13
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 23/8/13	
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 18.07.13
2	External Relief Dia	8.5 H/C (3-3)	Outside	Inner
3	External Relief Depth	25 H/C	20 H/C	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ravi	
6	Material Sent For Hardening On Date		23 6 25	
Inspected By (Sign) & Date			Ravi 23/8/13	

Reviewed by (Engineer-CNC)

Manager-QA