



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15271	40/45
2	Machined By		V. T. L H/c Shop	Dr. H. 18.01.25
3	Pallet Die No.		14953 (6.0) H	Rev 200
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	51.0 H, Step 002 492 H	Step length = 3
6	Inside Diameter	Drg. No.	420.14 H	
7	Width of Pellet Die	Drg. No.	152 H	
8	Grooves as per Drawing	Drg. No.	117.5 x 3 H / 117.5 x 3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		456 H	
13	Tapping Hole Diameter		0.314" 2 Check by 0.314" Bolt	Tabbing of Holes. B Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 16.8 H	Tabbing Depth 19.6
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							Counter 6.0
2	External Relief Dia	6.5 H	Outside C2-25		Inner				Rev: 15
3	External Relief Depth		11 H		5 H				
4	Inspection Done Before Hardening By (Name)								Rev:
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		24	6	25				

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA