



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)

10158

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15244	45/55
2	Machined By		V.T.L. H/C Shop	Dy. (28/07/13)
3	Pallet Die No.		12395(7.0) H/C	Rev. 100
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	630 H/C Step 002	1.9 H/C Step length 9.
6	Inside Diameter	Drg. No.	520.14 H/C	
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 H/C	13 x 8 x 5 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		H20. Crack by H20 Bolt	Tapping Holes 12 Bolt Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/C	Tapping Depth 18.
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 26/07/13

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

Counter 65
Rev 20

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	7.5 H/C	20.3-3)		Inner		
3	External Relief Depth		17 H/C		10 H/C		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Furnace		
6	Material Sent For Hardening On Date		26	6	25		

Inspected By (Sign) & Date

Ravi 26/07/13

Reviewed by (Engineer-CNC)

Manager-QA