



Lark Engineering Company (India) Pvt. Ltd.

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

10271

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		15406 ✓	19/06 ✓
3	Pallet Die No.		V.T.L. H/c Shop	Drg No. 18.0.009
4	Die Category	Drg. No.	15170 (6.0) mm ✓	Rev 03
5	Out Side Diameter	Drg. No.	M. 70 mm	Case 4x5
6	Inside Diameter	Drg. No.	680.7 mm ✓	Step 60. 693 mm ✓
7	Width of Pellet Die	Drg. No.	546.12 mm (Bore 548.4) mm ✓	Step length = 31 mm ✓
8	Grooves as per Drawing	Drg. No.	195 mm ✓	Under cut = 2.5 mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.2 mm 32 x 7 x 9.2 mm ✓	
10	Drilling Area Surface Smoothness		OK	Face Side 3th
11	Tapping Operator		OK	2nd Side 3th
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		619 mm ✓	
14	Tapping On Second Side	Half pitch of 1st side	H/c Shop	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		OK	
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

Counter 30
Rev 12

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	7.5 mm	11	Rows			
3	External Relief Depth			47 mm			
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

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Reviewed by (Engineer-CNC)

Manager-QA