



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.			
2	Machined By			
3	Pallet Die No.		15363 ✓	45/50 ✓
4	Die Category	Drg. No.	N/A Stop	1 Dy. H. 13.24 ✓
5	Out Side Diameter	Drg. No.	14868 (3.2) H7	Revised
6	Inside Diameter	Drg. No.	2nd side	
7	Width of Pellet Die	Drg. No.	620 H7 / Step on 622.2 H7	Tap hole 12 ✓
8	Grooves as per Drawing	Drg. No.	520.14 H7	Step length 18 H7
9	Fitting Sizes on CNC Plate	Drg. No.	222 H7	Under cut 1.2 H7
10	Drilling Area Surface Smoothness	Drg. No.	13 x 8 x 5 H7 / 13 x 8 x 5 H7	
11	Tapping Operator		OK	
12	Tapping PCD		OK	
13	Tapping Hole Diameter		N/A Stop	
14	Tapping On Second Side	Half pitch of 1st side	565 H7	Tapping of holes 12 ✓
15	Tapping Hole Depth		H20, Check by H20 8-12	Boh. 9 ✓
16	Perpendicularity of Tapped Hole		OK	
17	Visual Inspection Before Gun Drilling		Drill Depth 20.4 H7	Tapping Depth 18 ✓

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 - 6 ✓
2	External Relief Dia	2-8 H7	2-8 (3-3)	Inner				Rep. 3 ✓
3	External Relief Depth		12 H7	5 H7				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		10	7	25			

Inspected By (Sign) & Date

Reviewed by (Engineer-CNC)

Manager-QA