



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.		15442	35/40
2	Machined By		V.T.L. H/c Shop	By H. 18.08.1
3	Pallet Die No.		13943(3.2) H	Rev. 00
4	Die Category	Drg. No.	S&D	
5	Out Side Diameter	Drg. No.	500 H	Step 00. 490.7 H
6	Inside Diameter	Drg. No.	42.14 H	Step 16
7	Width of Pellet Die	Drg. No.	173 H	
8	Grooves as per Drawing	Drg. No.	12x10x5 H / 12x10x5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H. of Holes: 8
12	Tapping PCD		455 H	Both Side
13	Tapping Hole Diameter		03/4" = Check by 03/4" Bore	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H	Tapping Depth 18.0
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

Counter: 28

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	3.5 H	Outside 82.25		Inner			
3	External Relief Depth		7 H		5 H			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		15	7	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA