



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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. n/c Shop	Dr. No. 120-881
3	Pallet Die No.		13944(3.2)mm	Reverse
4	Die Category	Drg. No.	590	
5	Out Side Diameter	Drg. No.	499.9mm	Step 00.2 490.6mm
6	Inside Diameter	Drg. No.	420.14mm	Step length 18.5
7	Width of Pellet Die	Drg. No.	173mm	
8	Grooves as per Drawing	Drg. No.	12x10x5mm / 12x10x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		455mm	
13	Tapping Hole Diameter		03/4" 2 Check by 03/4" Ball	Tapping of hole 8
14	Tapping On Second Side	Half pitch of 1st side	ok	Both side
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.4mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sas: 19/7/15

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 - 1 Hole Colapsed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter. 60
2	External Relief Dia	3.5mm	outside 2-25		Inner			Row. 20
3	External Relief Depth		7mm		5mm			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		19	7	25			

Inspected By (Sign) & Date

Sas: 19/7/15

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Reviewed by (Engineer-CNC)

Manager-QA