



Lark Engineering Company (India) Pvt. Ltd.

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

10390

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		15585 ✓	36/50 ✓
3	Pallet Die No.		V.T.L. w/c Shop	6355
4	Die Category	Drg. No.	14627 (4.0) w/c	Drg. H. Lark 31.9
5	Out Side Diameter	Drg. No.	Ext. outside	
6	Inside Diameter	Drg. No.	62.44 Step 00. 611.9 w/c	Step length 19.5
7	Width of Pellet Die	Drg. No.	520.14 w/c	
8	Grooves as per Drawing	Drg. No.	222 w/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 w/c / 13x8x5 w/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		w/c Shop	
13	Tapping Hole Diameter		565 w/c	
14	Tapping On Second Side	Half pitch of 1st side	420, Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 w/c	Tapping Depth 18.4
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
4	Defective Holes (If Any)		ok	
			nil	

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

1	Counter Sinking Depth & Finish	ok								Counter Sink
2	External Relief Dia	4.5 w/c	outside (3-3)		inner					Row 31
3	External Relief Depth		18 w/c		14 w/c					
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

--	--	--	--	--	--	--	--	--	--	--

Reviewed by (Engineer-CNC)

Manager-QA