



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.		10438	33/40
2	Machined By		V.T.L n/c Shop	Drg No. = I.E.C. 15062
3	Pallet Die No.		10685 (3.0) n/c	Rev. no.
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c	Step no = 498.89
6	Inside Diameter	Drg. No.	490.12 n/c	Tappet = 12°
7	Width of Pellet Die	Drg. No.	158 n/c	Step length = 18 n/c
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes = 8 Both Side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		n/c = Check by n/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19.8 n/c	Tapping Depth = 17.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/10/13

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							Ravi 24
2	External Relief Dia	3.3 n/c	outside (2-2)		Inner				
3	External Relief Depth		13 n/c		7 n/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		13	10	23				

Inspected By (Sign) & Date

Ravi 13/10/13

Reviewed by (Engineer-CNC)
Sohi 13/10/13

Manager-QA