



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.		16085	22/33/66
2	Machined By		V. T. L. H/c Shop	Dy. No. 120339
3	Pallet Die No.		15754 (B.O.)	Rev. 08
4	Die Category	Drg. No.	H. 70mm	Chances
5	Out Side Diameter	Drg. No.	680.1 mm	Step 02. 692.9 mm
6	Inside Diameter	Drg. No.	546.12 mm	(B.O. 548.2) Taper - 8°
7	Width of Pellet Die	Drg. No.	195 mm	Step length 91 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 mm	(4 x 8)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 mm Deep
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		619 mm	Tapping H/c of holes
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	Tapping Depth 31.6
15	Tapping Hole Depth		Drill Depth 33.6 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 17/9/15

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

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

1	Counter Sinking Depth & Finish	OK						Counter 32
2	External Relief Dia	6.5 mm	11.0 mm	6.5 mm	All Rows 2	43 mm		Row 12
3	External Relief Depth			7.0 mm	All Rows 2	33 mm		
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date			17	9	25		

Inspected By (Sign) & Date

Ravi 17/9/15

Reviewed by (Engineer-CNC)

Manager-QA