



Lark Engineering Company (India) Pvt. Ltd.

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

10904

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		16280	40/55
3	Pallet Die No.		V.T.L. n/c Shop	Day 4. 120.55
4	Die Category	Drg. No.	16579(6.0)	Rev. 00
5	Out Side Diameter	Drg. No.	55370	
6	Inside Diameter	Drg. No.	630.44	Step 02. 623.84
7	Width of Pellet Die	Drg. No.	52.14	Step length 12
8	Grooves as per Drawing	Drg. No.	182	
9	Fitting Sizes on CNC Plate	Drg. No.	12x10x5	12x10x5
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		555	
14	Tapping On Second Side	Half pitch of 1st side	H162 Check by H16 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4	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	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							
2	External Relief Dia	6.5	Outside (3-3)		inner				
3	External Relief Depth		2.14		1.54				
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

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Reviewed by (Engineer-CNC)

Manager-QA