



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.		9758	45/45
2	Machined By		V.T.C. H/c Shop	Dwg No. 1.8.C.14949
3	Pallet Die No.		9123 (8.0) H/c	Rev: 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	509.7 H/c Step 00: 491 H/c	Step length: 17.4
6	Inside Diameter	Drg. No.	420.1 H/c	
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes: 8 Both Side
12	Tapping PCD		45 H/c	
13	Tapping Hole Diameter		H20 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.4 H/c Tapping Depth: 16.8 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi: 28/6/13	
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		Rep: 12
2	External Relief Dia	8.5 H/c	Outside (2.2)	Inner
3	External Relief Depth	✓	4 H/c	Nil
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		28	6
Inspected By (Sign) & Date			Ravi: 28/6/13	

Reviewed by (Engineer-CNC)

Manager-QA