



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10010646	33/40
2	Machined By		V.T.L. n/c Shop	Dry Hole 18.0, 768
3	Pallet Die No.		10398 (3.0) n/c	Rev 2.00
4	Die Category	Drg. No.	SEP	
5	Out Side Diameter	Drg. No.	500 n/c Step 002 499 n/c	Tappers 12°
6	Inside Diameter	Drg. No.	420.12 n/c	Step length 30 n/c
7	Width of Pellet Die	Drg. No.	182 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c 12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
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		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.8 n/c Tapping Depth 17 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rasi 10/11/13

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							Rev: 30
2	External Relief Dia	3.5 n/c	Outside (2-2)		Inner				
3	External Relief Depth		13 n/c		7 n/c				
4	Inspection Done Before Hardening By (Name)				Rasi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		10	11	23				

Inspected By (Sign) & Date

Rasi 10/11/13

Reviewed by (Engineer-CNC)

Manager-QA