



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)

Remarks

Observations

Specification

Check Parameter

S.No.

1	Work Order No.		16435 ✓	38/50
2	Machined By		N.T.L. n/c Shop	Drg No. 1.2.0.998
3	Pallet Die No.		15917 (4.0) n/c	Row 200
4	Die Category	Drg. No.	Extrusion Die	
5	Out Side Diameter	Drg. No.	62 n/c Step 00. Tappet 12"	
6	Inside Diameter	Drg. No.	52.14 n/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/c	Tapping No. of holes 12
13	Tapping Hole Diameter		42x2 Check by n/c Bolt	Both side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.4 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Row: 11/125

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 31
2	External Relief Dia	4.5 n/c	208 side 3-3)		Inner			
3	External Relief Depth		16 n/c		12 n/c			
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

Row: 11/125

Reviewed by (Engineer-CNC)

Manager-QA