



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.		10785	36/46/60 ✓
2	Machined By		V.T.L. N/c Shop	Drg No. 13.0.727
3	Pallet Die No.		11381 (4.0) H/H	Re 0200
4	Die Category	Drg. No.	Jumbo	✓
5	Out Side Diameter	Drg. No.	780 H/H Step 00.792 H/H	Step length 38.5
6	Inside Diameter	Drg. No.	380.12 H/H	Undercut B/H
7	Width of Pellet Die	Drg. No.	384 H/H	✓
8	Grooves as per Drawing	Drg. No.	21.5x8x8 H/H 21.5x8x8 H/H	
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 12 Both side
12	Tapping PCD		785 H/H	
13	Tapping Hole Diameter		M20 Check by H20 B-12	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 32.3 H/H	Tapping Depth 30 H/H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/7/13

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 - 4 Hole Closed 10

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

1	Counter Sinking Depth & Finish	OK								Re 247
2	External Relief Dia	4.5 H/H 5.0 H/H	4.5 H/H All Lines		5.0 H/H All Lines					
3	External Relief Depth		24 H/H		14 H/H					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Forance
6	Material Sent For Hardening On Date		8	12	23					

Inspected By (Sign) & Date

Ravi 31/7/13

Reviewed by (Engineer-CNC)

Manager-QA