



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.		10951	36/50
2	Machined By		N.T.L. n/c Shop	Dy. No. 12.02.12.50
3	Pallet Die No.		9973 (3.0) n/c	Recess
4	Die Category	Drg. No.	N. Tombo	
5	Out Side Diameter	Drg. No.	700 n/c	Step 00. 692.3mm Tapper. 12°
6	Inside Diameter	Drg. No.	200.12 n/c	Step length 20mm
7	Width of Pellet Die	Drg. No.	889 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x7 n/c / 12x8x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of hole. 12 Back Side
12	Tapping PCD		640 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 = 20.6mm Tapping Depth = 18.8mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rawal 19/12/13

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							Rawal 39
2	External Relief Dia	3.5mm	outside (3-2)		Inner				
3	External Relief Depth		20mm		14mm				
4	Inspection Done Before Hardening By (Name)								Rawal
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		19	12	23				

Inspected By (Sign) & Date

Rawal 19/12/13

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Reviewed by (Engineer-CNC)

Manager-QA