



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

6667

Inprocess Inspection (Pellet Dies)

Form No.	CNC/QA/FM/02
Rev. No.	01
Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10876	38/50
2	Machined By		V.T.L. H/o Shop	Dr. Moh. R. 31/7/13
3	Pallet Die No.		9975 (No.)	Dr. Rana
4	Die Category	Dr. No.	H. Jumbo	
5	Out Side Diameter	Dr. No.	700 H/H Step 002 693 H/H	Tapping No. 10
6	Inside Diameter	Dr. No.	600.12 H/H	Step length 10
7	Width of Pellet Die	Dr. No.	222 H/H	
8	Grooves as per Drawing	Dr. No.	12287 H/H / 12287 H/H	
9	Fitting Sizes on CNC Plate	Dr. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	Tapping No. 1
12	Tapping PCD		600 H/H	of holes, 12
13	Tapping Hole Diameter		N/A Check by H/O Bal	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.2 H/H	Tapping Depth = 19 H/H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date				
			Ravi 31/7/13	
Note : Mark the defective holes/missed holes with the help of Permanent Marker				
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 Hole Closed	
Note : Mark the defective holes/missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Ravi 31
2	External Relief Dia	U.5 H/H	60 Side (3-3)	10 H/H
3	External Relief Depth		16 H/H	12 H/H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porone	
6	Material Sent For Hardening On Date		31	12 23
Inspected By (Sign) & Date			Ravi 31/7/13	

Reviewed by (Engineer-CNC)

Manager-QA