



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.		10529	
2	Machined By		V.T.L. H/C Shop	45/55
3	Pallet Die No.		11375 (8.0) H4	Drg No. 1.2.0.407
4	Die Category	Drg. No.	H. Tomba	Revised
5	Out Side Diameter	Drg. No.	710 H4, Step 00, 692.8 H4	Tapper 12
6	Inside Diameter	Drg. No.	600.12 H4	Step length 20 H4
7	Width of Pellet Die	Drg. No.	222 H4	
8	Grooves as per Drawing	Drg. No.	12x8x7 H4 12x8x7 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		640 H4	Tapping No. of holes 12
13	Tapping Hole Diameter		N200 Check by H20 Bolt	Back side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21 H4 Tapping Depth 19 H4	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 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							
2	External Relief Dia	8.5 H4	Outside (2-3)	Inner					
3	External Relief Depth		18 H4	10 H4					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		19	12	23				

Inspected By (Sign) & Date

Ravi 19/12/13

Reviewed by (Engineer-CNC)

Manager-QA