



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.		10529	415/55
2	Machined By		V.T.L. n/c Shop	Drilling No. 1.8.02
3	Pallet Die No.		11374 (80) n/c	Rev 2.00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	710 n/c Step OD = 69.28 n/c	Tappet = 12
6	Inside Diameter	Drg. No.	600.14 n/c	Step length = 20 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 n/c / 12 x 8 x 7 n/c	
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		640 n/c	
13	Tapping Hole Diameter		420 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21 n/c Tapping Depth = 19 n/c	
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	

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

1	Counter Sinking Depth & Finish	ok							Row = 18
2	External Relief Dia	8.5 n/c	00Kide (3-5)		Inner				
3	External Relief Depth		18 n/c		10 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		21	12	23				

Inspected By (Sign) & Date

Ravi 31/7/13

Reviewed by (Engineer-CNC)

Manager-QA