



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.		10930	38/50
2	Machined By		V.T.L n/c Shop	Drg No. 1.5 D 322
3	Pallet Die No.		11333 (4.0) n/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 n/c Step 00, 500 n/c	Tapper 12
6	Inside Diameter	Drg. No.	420.12 n/c	Step length 18 n/c
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 n/c 12 x 8 x 3 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 = 8 Back side
12	Tapping PCD		455 n/c 454.9 n/c	
13	Tapping Hole Diameter		420 = Crack by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 192 n/c	Tapping Depth 172 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/12/13

1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		nk	

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 n/c	outside 2-2		inner				
3	External Relief Depth		16 n/c		12 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				22	12	23		
Inspected By (Sign) & Date		Ravi 22/12/13							

Reviewed by (Engineer-CNC)

Manager-QA