



Lark Engineering Company (India) Pvt. Ltd.

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

Form No.

CNC/QA/FM/02 6648

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10930	
2	Machined By		V.T.L. H/C Shop	38/50
3	Pallet Die No.		11334 (4.0) H/C	Dy. No. 13.0.322
4	Die Category	Drg. No.	Senior	Rev. No.
5	Out Side Diameter	Drg. No.	52.0 H/C Step OD 50.0 H/C	Tapper 10
6	Inside Diameter	Drg. No.	42.0 12 H/C	Step length 13 H/C
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/C / 12 x 8 x 3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		45.5 H/C	Tapping No. of Holes 2
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	Back Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19 H/C Tapping Depth 17 H/C	
16	Perpendicularity of Tapped Hole		YES	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 25/7/13

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								
2	External Relief Dia	4.5 H/C	Outside (2-2)		Inner					
3	External Relief Depth		16 H/C		12 H/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			25	12	25				

Inspected By (Sign) & Date

Ravi 25/7/13

Reviewed by (Engineer-CNC)

Manager-QA