

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.		10859	
2	Machined By		V.T.L. H/c Shop	30/40
3	Pallet Die No.		10936 (2.0) H/c	Digital 2015-02
4	Die Category	Drg. No.	Senior	Pass ok ✓
5	Out Side Diameter	Drg. No.	500 H/c Step 002 498.32 H/c	Tappes 12
6	Inside Diameter	Drg. No.	490.12 H/c	Step lengths 18 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	Tapping No. of Holes: 8 Both Side
12	Tapping PCD		450 H/c	
13	Tapping Hole Diameter		H/c = Check by H/c Ball	
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 Solanki

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

Counters 60°

1	Counter Sinking Depth & Finish	ok							Ravi 24
2	External Relief Dia	3.3 H/c	outside (2-2)		Inner				
3	External Relief Depth	✓	10 H/c		4 H/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Horner
6	Material Sent For Hardening On Date			30	12	23			

Inspected By (Sign) & Date

Ravi Solanki

Manager-QA

Reviewed by (Engineer-CNC)