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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.		11024	50/55
2	Machined By		V.T.C./C Shop	Day No. 18.09.10
3	Pallet Die No.		11568 (L.I.C) H-1	Revised
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	Flower Step dia 692-3mm	Tapper 12°
6	Inside Diameter	Drg. No.	Good H-1	Step length 12.5mm
7	Width of Pellet Die	Drg. No.	882 H-1	
8	Grooves as per Drawing	Drg. No.	12x8x7 H-1	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping N/C
12	Tapping PCD		240 H-1	of 2. Nov 12
13	Tapping Hole Diameter		Max Check by H-20 Bolt	Q.A. side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21 H-1	Depth = 19 H-1
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date				
1	As per programme no.		Ravi	
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
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		Counter = 60°
2	External Relief Dia	4.5 H-1	Outside (23-3) Inner 3mm	Revised
3	External Relief Depth		11 H-1	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lank Forward	
6	Material Sent For Hardening On Date		4 1 24	
Inspected By (Sign) & Date				
 Ravi 4/1/14				

Reviewed by (Engineer-CNC)

Manager-QA