



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.		11134	32/38
2	Machined By		V.T.L. H/c Shop	Dy. No. 12.02.961
3	Pallet Die No.		11594 (2.8) H/c	Rev. 00
4	Die Category	Drg. No.	Ext. & side	
5	Out Side Diameter	Drg. No.	596 H/c, Step 00, 621.4 H/c	Tapping 12
6	Inside Diameter	Drg. No.	520.12 H/c	Step length 2.5
7	Width of Pellet Die	Drg. No.	222 H/c	Under cut = 12.7
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 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 = 12 Beta Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H2 = Check by H2 = Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.3 H/c	Tapping Depth = 19 H/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 20/12/14

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					Counter 60° Rev. 39
2	External Relief Dia	3.3 H/c	Outside (3-3)	Inner			
3	External Relief Depth		12 H/c	6 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		20	1	24		

Inspected By (Sign) & Date

Ravi 20/12/14

Satish 20/12/14

Reviewed by (Engineer-CNC)

Manager-QA