



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.		11182	48/50
2	Machined By		V.T.L n/c Shop	0355 Dy. n/c work 519
3	Pallet Die No.		11954 (4.0) n/c	
4	Die Category	Drg. No.	Ext. inside	
5	Out Side Diameter	Drg. No.	620 n/c, Step 60-612 n/c	Step length 19.4
6	Inside Diameter	Drg. No.	520.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of holes 12 Bottom side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 24.4 n/c	Tapping Depth - 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 30/7/13*

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 *Counter 60°*

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.3 n/c	outside (3-3)		inner				
3	External Relief Depth		10 n/c		2 n/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date *Ravi 30/7/13*

Reviewed by (Engineer-CNC)

Manager-QA