



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.		10919	40/50
2	Machined By		V.T.L n/c Shop	Digital Lark 3510
3	Pallet Die No.		11258 (3.2) n/c	
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	620 n/c, Step 0.2 612 n/c	Step length 19.5 n/c
6	Inside Diameter	Drg. No.	520.12 n/c / 520.14 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 No. of holes 12 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.4 n/c Tapping Depth 19 n/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 21/7/14	
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
2	External Relief Dia	3.8 n/c	Outside (3-3)	Ravi 21/7/14
3	External Relief Depth		16 n/c	Inner 10 n/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		2 2 24	
Inspected By (Sign) & Date			Ravi 21/7/14	

Reviewed by (Engineer-CNC)

Manager-QA