



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.		111001	36/40
2	Machined By		V.T.L. H/c Shop	Drg. No. 395
3	Pallet Die No.		11591 (4.0) H/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4.00 H/c - Step 00 - 395 H/c	Step length 4.4
6	Inside Diameter	Drg. No.	3.95 H/c	
7	Width of Pellet Die	Drg. No.	14.8 H/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H/c 15.5 x 7 x 2 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 Hold. 8 Rote side
12	Tapping PCD		355 H/c	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.4 H/c	Tapping Depth = 18.3 H/c
16	Perpendicularity of Tapped Hole		YES	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/7/14

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					Counters 16
2	External Relief Dia	4.5 H/c	Outside (8-2)	Inner			
3	External Relief Depth	/	8 H/c	4 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		3	2	24		

Inspected By (Sign) & Date

Ravi 31/7/14

Reviewed by (Engineer-CNC)

Manager-QA