



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.		11150/	40/40
2	Machined By		V. T. L. H/C Shop	Drg No. 3109
3	Pallet Die No.		11501 (21.0) H/C	3110
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 H/C, Step 60, 395 H/C	Step length 14.4
6	Inside Diameter	Drg. No.	320.12 H/C	
7	Width of Pellet Die	Drg. No.	142.1 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 holes 8 Both side
12	Tapping PCD		355 H/C	
13	Tapping Hole Diameter		H16.2 Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21 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 31/7/13

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

Count on 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 H/C	outside (2-2)		Inner				
3	External Relief Depth	/	4 H/C		Nil				
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 31/7/13

Reviewed by (Engineer-CNC)

Manager-QA