



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.		11231	38/55
2	Machined By		V. T. L H/C Shop	Depth 1.8.0.4.7
3	Pallet Die No.		11783 (4.0) H/C	Recess
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710 H/C, Step 0.02 692.8 H/C	Tapping 12°
6	Inside Diameter	Drg. No.	600.12 H/C	Step length 19.8
7	Width of Pellet Die	Drg. No.	999 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x7 H/C / 12x8x7 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 Both side
12	Tapping PCD		640 H/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 81.4 H/C	Tapping Depth 19.8 H/C
16	Perpendicularity of Tapped Hole		YES	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 21/7/13	
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				
1	Counter Sinking Depth & Finish	OK	Counter 60° Ravi 21/7/13	
2	External Relief Dia	4.5 H/C	Outside (3-3)	Inner
3	External Relief Depth		91 H/C	17 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Forance	
6	Material Sent For Hardening On Date		2	2 24
Inspected By (Sign) & Date			Ravi 21/7/13	

Reviewed by (Engineer-CNC)

Manager-QA