



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.			
2	Machined By		11935	30/40
3	Pallet Die No.		V.T.I. 4/c Shop	Drg. No. - Lark 3370
4	Die Category	Drg. No.	10986 (3.0) 4/c	
5	Out Side Diameter	Drg. No.	SE 10	
6	Inside Diameter	Drg. No.	500H, Step 002 491H	Step length: 17.4H
7	Width of Pellet Die	Drg. No.	480.12 H	
8	Grooves as per Drawing	Drg. No.	18.2 H	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3H 12x8x3H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		N/C Shop	Tapping No. of holes: 8 Both Side
13	Tapping Hole Diameter		454H	
14	Tapping On Second Side	Half pitch of 1st side	M2: Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 19.9H Tapping Depth: 17H	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 5/8/14

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 - 1 Hole Colused

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	3.3H	outside (2-2)	inner				160230
3	External Relief Depth		13H	10H				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		5	2	24			

Inspected By (Sign) & Date

Ravi 5/8/14

Reviewed by (Engineer-CNC)

Manager-QA