



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.		11105	33/50
2	Machined By		V.T.L. n/c Shop	Drg No. 18.0.450
3	Pallet Die No.		11520 (3.0) H4	Rev = 00
4	Die Category	Drg. No.	7820	
5	Out Side Diameter	Drg. No.	730 H4	Step 002 743 H4 Tapper 10°
6	Inside Diameter	Drg. No.	630.12 H4	Step length 32 H4
7	Width of Pellet Die	Drg. No.	290 H4	Under cut 6.3 H4
8	Grooves as per Drawing	Drg. No.	15x8x7 H4 15x8x7 H4	
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 16 Beta Side
12	Tapping PCD		685 H4	
13	Tapping Hole Diameter		M 20.2 Check by size Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.5 H4	Tapping Depth 19 H4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 31/8/14	
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counters 60° Rows 52
2	External Relief Dia	3.5 H4	Outside (2-3)	Inner
3	External Relief Depth		23 H4	17 H4
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark for name	
6	Material Sent For Hardening On Date		8	2 24
Inspected By (Sign) & Date			Ravi 31/8/14	

Reviewed by (Engineer-CNC)

Manager-QA