



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.		11246	22/45
2	Machined By		V.T.L. N/C Shop	Dy No. 1-2-10-519
3	Pallet Die No.		11213 (2-3) H4	Pen 2 on
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	690 H4, Step 00, 692 H4	Step length 2mm
6	Inside Diameter	Drg. No.	600.12 H4	Under cut 1mm
7	Width of Pellet Die	Drg. No.	222 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 12 Both side
12	Tapping PCD		640 H4	
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.7 H4 Tapping Depth 19 H4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi Halay	
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 Pen = 39
2	External Relief Dia		3.1 H4	Outside (2-3) Inner
3	External Relief Depth		20 H4	17 H4
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		7 2 24	
Inspected By (Sign) & Date			Ravi Halay	

Reviewed by (Engineer-CNC)

Manager-QA