



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.		11251	34/50
2	Machined By		V.T.L n/c Shop	Drg No. 1390033
3	Pallet Die No.		11394 (4.0)mm	Revised
4	Die Category	Drg. No.	33310	
5	Out Side Diameter	Drg. No.	62.01 mm, Step 002 62.32 mm	Tapless 12
6	Inside Diameter	Drg. No.	52.12 mm	Step length 2 mm
7	Width of Pellet Die	Drg. No.	186 mm	Under cut 1.6 mm
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 mm	Tapping n/c of holes 12 Both side
13	Tapping Hole Diameter		M16 - Check by M16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.4 mm Tapping Depth 19 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 9/8/14

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						Counter Go
2	External Relief Dia	4.5 mm	Outside (3-3)		Inner			Rev 285
3	External Relief Depth		2.0 mm		16 mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		9	8	24			
Inspected By (Sign) & Date		Ravi 9/8/14						

Reviewed by (Engineer-CNC)

Manager-QA