



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.		11998	28/38/66
2	Machined By		M.T.C. H/O Shop	Drg No. 1.30.609
3	Pallet Die No.		11909 (6.0) H/O	Rev. 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 H/O Step 00 = 693 H/O	Tapper 8°
6	Inside Diameter	Drg. No.	548.12 H/O	Step length 3 H/O
7	Width of Pellet Die	Drg. No.	195 H/O	Under cut 2.5 H/O
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/O	(4 x 8) H/O
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Place Side Step 9 H/O
10	Drilling Area Surface Smoothness		ok	Drill Both Side
11	Tapping Operator		H/O Shop	Tapping No. of Holes = 4 Both Side
12	Tapping PCD		619 H/O	
13	Tapping Hole Diameter		MIG = Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 H/O	Tapping Depth = 31.6 H/O
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 13/8/14

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 = 35
2	External Relief Dia	6.5 H/O	7.0 H/O	6.5 H/O	1 Rows	7.0 H/O	11 Rows
3	External Relief Depth			38 H/O		28 H/O	
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Ferrace
6	Material Sent For Hardening On Date			13	2	24	

Inspected By (Sign) & Date Ravi 13/8/14

Reviewed by (Engineer-CNC) Sohr 13/8/14

Manager-QA