



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11302	45/50
2	Machined By		V. T. L. H/c Shop	Dry Nos. 1.8.02 370
3	Pallet Die No.		11708 (G.O) H/c	Rev. 20
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519 H/c Step 002 491 H/c	Step length 19 H/c
6	Inside Diameter	Drg. No.	420.12 H/c	17.5
7	Width of Pellet Die	Drg. No.	159.5 H/c	
8	Grooves as per Drawing	Drg. No.	13.5 x 8 x 3 H/c / 13 x 8 x 3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c	Tapping No of holes 8
13	Tapping Hole Diameter		Ø 3/4" 2 Check by Ø 3/4" Bolt	Both side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19 H/c Tapping Depth 17 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 26/7/13

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°
2	External Relief Dia	6.5 H/c	Outside (2-2)		Inner			Rev 2 15
3	External Relief Depth		11 H/c		5 H/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		26	2	24			
Inspected By (Sign) & Date		Ravi 26/7/13						

Reviewed by (Engineer-CNC)

Manager-QA