



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

70/4

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11419	36/36
2	Machined By		V. T. L. n/c Shop	Dr. No. 1 & 2 = 458
3	Pallet Die No.		10992 (3.0) n/c	Rev. 100
4	Die Category	Drg. No.	SE 10	
5	Out Side Diameter	Drg. No.	492 n/c, Step 002 491 n/c	Step length 16.9
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	182 n/c	
8	Grooves as per Drawing	Drg. No.	10x10x5 n/c / 10x10x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Ho of holes = 8 Both Side
12	Tapping PCD		455 n/c	
13	Tapping Hole Diameter		0.234" = Check by 0.234" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20 n/c Tapping Depth 17.5 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/7/14

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 - 1 Hole Closed (D)

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	3.5 n/c	outside (2-2)		inner			
3	External Relief Depth		4 n/c		Nil			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Porrace
6	Material Sent For Hardening On Date			27	2	24		

Inspected By (Sign) & Date

Ravi 27/7/14

Satsou 27/7/14

Reviewed by (Engineer-CNC)

Manager-QA