



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)

7030

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11304	40/50
2	Machined By		V.T.L n/c Shop	Drg No. 13.02.493
3	Pallet Die No.		11216 (4.0) n/c	Rev 2.00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 n/c Step OD = 698.8 n/c	Tappes = 12
6	Inside Diameter	Drg. No.	600.12 n/c	Step length = 19.8
7	Width of Pellet Die	Drg. No.	222.14 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 7.5 n/c / 12 x 10 x 7.5 n/c	
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 Rota Side
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21 n/c Tapping Depth 18.8 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/8/14

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

Counter = 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.5 n/c	20 side (3-3)		Inner					
3	External Relief Depth		14 n/c		10 n/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		28	2	24					

Inspected By (Sign) & Date

Ravi 28/8/14

25/8/14

Reviewed by (Engineer-CNC)

Manager-QA