



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.		11339	27/55
2	Machined By		V.T.L. H/c Shop	Dry H/c (3.0) = 594
3	Pallet Die No.		12183 (4.5) H/c	Rev 2.00
4	Die Category	Drg. No.	5212	
5	Out Side Diameter	Drg. No.	530 H/c Step OD: 491 H/c	Step length: 17.4
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	182 H/c	
8	Grooves as per Drawing	Drg. No.	10x8x3 H/c 10x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of holes: 8 Both Side
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		03/4" = Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 19.3 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 29/3/14	
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		Count 21260 Ravi 23
2	External Relief Dia	5.5 H/c	Outside (2-2)	Inner
3	External Relief Depth		32 H/c	28 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		29	3 24
Inspected By (Sign) & Date			Ravi 29/3/14	

Reviewed by (Engineer-CNC)

Manager-QA