



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.		11583	48/55
2	Machined By		V.T.C. n/c Shop	Drg No. 18.02.355
3	Pallet Die No.		12154 (4.0) n/c	Rev. 00
4	Die Category	Drg. No.	53510	
5	Out Side Diameter	Drg. No.	630 n/c / Step 002 612 n/c	Step length 20 n/c
6	Inside Diameter	Drg. No.	520.12 n/c	
7	Width of Pellet Die	Drg. No.	186 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x3 n/c / 13x8x3 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 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.7 n/c	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 21/7/14

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

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	4.5 n/c	Outside (3-3)	Inner			Low 25
3	External Relief Depth		17 n/c	13 n/c			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Purchase
6	Material Sent For Hardening On Date		2	4	24		

Inspected By (Sign) & Date Ravi 21/7/14

Satish
21/7/14
Reviewed by (Engineer-CNC)

Manager-QA