



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.		11743	
2	Machined By		V. T. L. n/c Shop	36/55
3	Pallet Die No.		12144 (4.0) n/c	Drg No. 130.407
4	Die Category	Drg. No.	N. Jumbo	Rev. 02
5	Out Side Diameter	Drg. No.	710 n/c	Step no. 692
6	Inside Diameter	Drg. No.	600.12 n/c	7 n/c Tapped
7	Width of Pellet Die	Drg. No.	222 n/c	Step length 2 n/c
8	Grooves as per Drawing	Drg. No.	12+8+7 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		640 n/c	
13	Tapping Hole Diameter		N20, Check by n/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.8 n/c	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raoi 18/4/14

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 (3-31)		Inner			Low 32
3	External Relief Depth		23 n/c		19 n/c			
4	Inspection Done Before Hardening By (Name)							Raoi
5	Material Sent For Hardening By (Name)							Lark Porrace
6	Material Sent For Hardening On Date		18	4	24			

Inspected By (Sign) & Date

Raoi 18/4/14

Sat 18/4/14

Reviewed by (Engineer-CNC)

Manager-QA