



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7436

Form No.	CNC/QA/FM/02
Rev. No.	01
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

Ham
2040
S02

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11842	35/50
3	Pallet Die No.		V. T. L. n/a Shop	Dy. No. 65009980
4	Die Category	Drg. No.	12115 (B.O) n/a	20000
5	Out Side Diameter	Drg. No.	Extra wide	
6	Inside Diameter	Drg. No.	6.20mm - 5.75mm	Tapping 12 - 3/16" dia
7	Width of Pellet Die	Drg. No.	5.20mm	
8	Grooves as per Drawing	Drg. No.	2.20mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5mm 13x8x5mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/a Shop	Tapping n/a
13	Tapping Hole Diameter		5.65mm	of Hole 12
14	Tapping On Second Side	Half pitch of 1st side	n/a Check by H2 Bolt	Back Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 20.8mm	Tapping Depth = 13.8
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Raw: 6/5/14

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					Raw: 6/5/14
2	External Relief Dia	B. Butt	20 side (2.3)	1mm			
3	External Relief Depth		20mm	14mm			
4	Inspection Done Before Hardening By (Name)						Raw
5	Material Sent For Hardening By (Name)						Lark Purvach
6	Material Sent For Hardening On Date		6	5	24		

Inspected By (Sign) & Date

Raw: 6/5/14

Satish 6/5/14

Reviewed by (Engineer-CNC)

Manager-QA