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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.		14674 ✓	33/38
2	Machined By		M.T.C. H/O Shop	Dy. No. 18.0.1098
3	Pallet Die No.		14374 (3.0) mm	Rev. No. 1
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	676 mm Step on = 703 mm	Tabber 4.5
6	Inside Diameter	Drg. No.	300.12 mm	Step length = 93.5
7	Width of Pellet Die	Drg. No.	250 mm	Under cut = 13.5 mm
8	Grooves as per Drawing	Drg. No.	24x5x9 mm 24x5x9 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	Tapping H/O of holes 12 Both Side
12	Tapping PCD		655 mm	
13	Tapping Hole Diameter		M16 Check by M16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 24.4 mm	Tapping Depth = 28.9 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Soni 16/4/15	
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 Bt 40x241
2	External Relief Dia	3.5 mm	Outside (3-3)	Inner
3	External Relief Depth	11 mm	5 mm	
4	Inspection Done Before Hardening By (Name)		Soni	
5	Material Sent For Hardening By (Name)		Lark Pomece	
6	Material Sent For Hardening On Date		16	4
Inspected By (Sign) & Date			Soni 16/4/15	

Reviewed by (Engineer-CNC)

Manager-QA