



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.		15876	50/50
2	Machined By		V. T. L. N/C Shop	Done 12.0.15
3	Pallet Die No.		15782 (G.O.)	Done
4	Die Category	Drg. No.	7810	
5	Out Side Diameter	Drg. No.	730mm	Step 00, 744mm Tapper 10°
6	Inside Diameter	Drg. No.	630.14mm	Step length 93.5
7	Width of Pellet Die	Drg. No.	290.18mm	Code cut, 7mm
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5 mm / 15.3 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		885mm	
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 20.5mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 29/25

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							
2	External Relief Dia	6.5mm	20 Side	Inner					
3	External Relief Depth	6mm		Mill					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Ravi					
6	Material Sent For Hardening On Date		2	9	25				

Inspected By (Sign) & Date

Ravi 29/25

Satya 29/25

Reviewed by (Engineer-CNC)

Manager-QA