



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.		16123	38/51
2	Machined By		V.T.L. n/c Shop	Drill 18.0.537
3	Pallet Die No.		12910(3.0)mm	R. 2.00
4	Die Category	Drg. No.	Mr. Jomho	
5	Out Side Diameter	Drg. No.	732mm - Step 00. 742.9mm	
6	Inside Diameter	Drg. No.	630.14mm	Tapper 40
7	Width of Pellet Die	Drg. No.	255mm	Step length 27.5
8	Grooves as per Drawing	Drg. No.	22x8x7mm / 22x8x7mm	Under cut 5.5mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		685mm	Tapping Holes 12
13	Tapping Hole Diameter		M22.2 Check by M22 Roll	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 28.4mm	Tapping Depth 96.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

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 - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok								Counter Sinking
2	External Relief Dia	3.5mm	OK side (3-3)			inner				Rev. 42
3	External Relief Depth		19mm			13mm				
4	Inspection Done Before Hardening By (Name)					Ravi				
5	Material Sent For Hardening By (Name)					Lark Forware				
6	Material Sent For Hardening On Date			10	10	25				

Inspected By (Sign) & Date

Reviewed By (Engineer-CNC) Manager-QA