



Lark Engineering Company (India) Pvt. Ltd.

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

11002

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.		16346	6060
2	Machined By		V. T. L. n/c Shop	Dry W. 12.0.1362
3	Pallet Die No.		16527(4.0)mm	Rev. 00
4	Die Category	Drg. No.	742	
5	Out Side Diameter	Drg. No.	749.9 mm Step 002	743.9 mm Tapper. 10
6	Inside Diameter	Drg. No.	630.14 mm	Step Length. 23.3
7	Width of Pellet Die	Drg. No.	290.6 mm	
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	Face Side Step
11	Tapping Operator		n/c Shop	0.8 mm Deep
12	Tapping PCD		685 mm	Both Side
13	Tapping Hole Diameter		M20, Check by M20 B.	Tapping H.
14	Tapping On Second Side	Half pitch of 1st side	OK	of Holes 216
15	Tapping Hole Depth		Drill Depth. 20.4 mm	Both Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth. 18.4
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rev: 31/125

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							Count on Rev: 43
2	External Relief Dia	4.5 mm	Outside (3-3)		Inner				
3	External Relief Depth		5 mm		N:11				
4	Inspection Done Before Hardening By (Name)				Rev:				
5	Material Sent For Hardening By (Name)				Lark Purnooce				
6	Material Sent For Hardening On Date		3	11	25				

Inspected By (Sign) & Date

Rev: 31/125

Reviewed by (Engineer-CNC)

Manager-QA