



# 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.		12297	53/60
2	Machined By		V.T.G. n/c. Shop	Dy. 1/2/12 915
3	Pallet Die No.		12470 (3.8) n/c	Rev 2 00
4	Die Category	Drg. No.	Ext. side	
5	Out Side Diameter	Drg. No.	64.0 n/c / 3.8 002	615.5 n/c / 3.8 002
6	Inside Diameter	Drg. No.	52.0 n/c	Tapping 4-
7	Width of Pellet Die	Drg. No.	22.2 n/c	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 n/c / 13 x 8 x 5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping 2-
12	Tapping PCD		56.5 n/c	of holes 2
13	Tapping Hole Diameter		M20 Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 n/c	Tapping Depth 18-
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 9/7/12

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 = 60
2	External Relief Dia	6.3 n/c	outside (3-3)		Inner				Low = 33
3	External Relief Depth		14 n/c		7 n/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		9	7	24				
Inspected By (Sign) & Date				Ravi 9/7/12					

Reviewed by (Engineer-CNC)

Manager-QA