



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13098 ✓	40/40 ✓ 195
2	Machined By		V.T.L. N/A Shop	Drg No. Lark SST ✓
3	Pallet Die No.		8923(3.5) ✓	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 ✓ Step 002 49 ✓	Step length 7.5 ✓
6	Inside Diameter	Drg. No.	420.12 ✓	
7	Width of Pellet Die	Drg. No.	158 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 ✓ / 12x8x3 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/A Shop	Tapping No. of Holes: 8 Both Side
12	Tapping PCD		454 ✓	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 ✓	Tapping Depth 18 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 31/07/13	
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				Counters 600
1	Counter Sinking Depth & Finish	ok		Ravi 22 ✓
2	External Relief Dia	4.0 ✓	Outside (2.2)	Inner
3	External Relief Depth		7mm	11mm
4	Inspection Done Before Hardening By (Name)		Ravi ✓	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		8	10 24
Inspected By (Sign) & Date			Ravi 31/07/13	

Reviewed by (Engineer-CNC)

Manager-QA