

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.		13204 ✓	40/40 ✓
2	Machined By		V.T.L. N/c Shop	Drg No. Lark 310
3	Pallet Die No.		12740(4.0) ✓	
4	Die Category	Drg. No.	SEP ✓	
5	Out Side Diameter	Drg. No.	500 ✓ Step 00 = 491 ✓	Step length = 5
6	Inside Diameter	Drg. No.	420.12 ✓	
7	Width of Pellet Die	Drg. No.	182 ✓	
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/c Shop	Tapping No. of holes = 8 Both Side
12	Tapping PCD		454 ✓	
13	Tapping Hole Diameter		M20.2 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 16.5 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 28/10/14	
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 Sink Low 25
2	External Relief Dia	4.5 ✓	Outside (2-2)	Inner
3	External Relief Depth	—	4 ✓	Null
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		28 10 24	
Inspected By (Sign) & Date			Ravi 28/10/14	

Reviewed by (Engineer-CNC)

Manager-QA