



# 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.		13434	36/45/50
2	Machined By		V.T.L. N/C Shop	Drg No. 13022359
3	Pallet Die No.		13472 (4.0) M4	Row 02
4	Die Category	Drg. No.	Extrusion die	
5	Out Side Diameter	Drg. No.	6.20 M4 Step 0.02 6.24 M4	Tabber 123
6	Inside Diameter	Drg. No.	5.80 1.2 M4	Step length 13 M4
7	Width of Pellet Die	Drg. No.	2.2 M4	Under cut 2 M4
8	Grooves as per Drawing	Drg. No.	13x8x5 M4   13x8x5 M4	
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 = 12 Both Side
12	Tapping PCD		5.65 M4	
13	Tapping Hole Diameter		M2 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 M4 Tapping Double 12.6	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 11/12/14

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

Counter, 60

1	Counter Sinking Depth & Finish	OK						Row 31
2	External Relief Dia	4.5 M4 / 5.0 M4	4.5 M4 All Rows = 14 M4					
3	External Relief Depth		5.0 M4 All Rows = 5 M4					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Forging					
6	Material Sent For Hardening On Date		7	12	24			

### Inspected By (Sign) & Date

Ravi 11/12/14

Reviewed by (Engineer-CNC)  
Sats 10/11/14

Manager-QA