



# 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.		13626 ✓	38/45	
2	Machined By		V. T. L. N/A Shop	Drg No. 630, 433	
3	Pallet Die No.		13124 (3.2) H-1	Rev. 00	
4	Die Category	Drg. No.	SEW		
5	Out Side Diameter	Drg. No.	510 H-1 Step OD = 491 H-1	Step length 17.5	
6	Inside Diameter	Drg. No.	420.12 H-1		
7	Width of Pellet Die	Drg. No.	182 H-1		
8	Grooves as per Drawing	Drg. No.	12x8r3 H-1 / 12x8r3 H-1		
9	Fitting Sizes on CNC Plate	Drg. No.	ok		
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		N/A Shop	Tapping H <sub>2</sub> O of holes, 8 Back Side	
12	Tapping PCD		454 H-1		
13	Tapping Hole Diameter		H <sub>2</sub> O - Check by H <sub>2</sub> O Bolt		
14	Tapping On Second Side	Half pitch of 1st side	ok		
15	Tapping Hole Depth		Drill Depth = 18.3 H-1	Tapping Depth = 16.5 H-1	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 20/12/14		
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		Rev. 28	
2	External Relief Dia	3.5 H-1	outside (2-2)	Inner	
3	External Relief Depth		13 H-1	7 H-1	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Furnace		
6	Material Sent For Hardening On Date		20	12	24
Inspected By (Sign) & Date			Ravi 20/12/14		

Reviewed by (Engineer-CNC)  
S. S. S. 20/12/14

Manager-QA