



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.		13656	45/50/5555
2	Machined By		V.T.L n/c Shop	Dy. No. Lark 3570
3	Pallet Die No.		13665 (3.5) n/c	
4	Die Category	Drg. No.	Perbawide	
5	Out Side Diameter	Drg. No.	619.9 n/c, Step 002 611.9 n/c	Step length 17.5
6	Inside Diameter	Drg. No.	580.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 n/c	
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		565 n/c	
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 20.2 n/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Raoi 11/125	
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		Counters Go
2	External Relief Dia	4.0 n/c	Outside (3-3)	Lower 35
3	External Relief Depth		12 n/c	Inner 5 n/c
4	Inspection Done Before Hardening By (Name)		Raoi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		1 1 25	
Inspected By (Sign) & Date			Raoi 11/125	

Reviewed by (Engineer-CNC)

Manager-QA