



# 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.		13557 ✓	410/50 ✓
2	Machined By		V.T.L H/C Shop	Drg No. 1.302-1219
3	Pallet Die No.		14087 (5.0) ✓	Row 2 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5.20 ✓, Step 00. 492 ✓	Step length 17.5 ✓
6	Inside Diameter	Drg. No.	4.20.12 ✓	
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		H/C Shop	Tapping No. of Holes = 9
12	Tapping PCD		454 ✓	
13	Tapping Hole Diameter		M2x2 Check by M2 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3 ✓	Tapping Depth 16.6 ✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 31/7/13

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

1	Counter Sinking Depth & Finish	ok						Counter = 60° Row = 17
2	External Relief Dia	5.5 ✓	outside (2-2)		Inner			
3	External Relief Depth		15 ✓		10 ✓			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date		3	1	25			

### Inspected By (Sign) & Date

Ravi 31/7/13

Reviewed by (Engineer-CNC)

Manager-QA