



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.		13809	40/40
2	Machined By		V.T.L. n/c Shop	8195 Dy. n/c Lark 2370
3	Pallet Die No.		13225(5.0) n/c	
4	Die Category	Dr. No.	Senior	
5	Out Side Diameter	Dr. No.	499.9 n/c	Step 002 490.9 n/c Step length 17.0
6	Inside Diameter	Dr. No.	420.12 n/c	
7	Width of Pellet Die	Dr. No.	158 n/c	
8	Grooves as per Drawing	Dr. No.	12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Dr. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of holes 28 Both Side
12	Tapping PCD		454 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 18.2 n/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/12/13

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° Ravi 17
2	External Relief Dia	5.5 n/c	Outside (2-2)	Inner				
3	External Relief Depth		5 n/c	Nil				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		21	1	25			

Inspected By (Sign) & Date

Ravi 21/12/13

Reviewed by (Engineer-CNC)

Manager-QA