



# 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.		13705 ✓	32/40 ✓
2	Machined By		V.T.L. H/O Shop	Dy. No. 1-2-01/5069
3	Pallet Die No.		12449(3.2) ✓	Rev. 00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 ✓, Step 00, 498.0	Tappet 123
6	Inside Diameter	Drg. No.	42.12 ✓	Step length 12 ✓
7	Width of Pellet Die	Drg. No.	158 ✓	
8	Grooves as per Drawing	Drg. No.	12x 8r 3 ✓ / 12x 8r 3 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/O Shop	Tapping of holes 2 B Bolt side
12	Tapping PCD		454 ✓	
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 18.3 ✓ Tapping Depth 18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 6/25

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 - 1 Hole Closed (A)

**Note : Mark the defective holes/missed holes with the help of Permanent Marker**

Counter 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.8 ✓	3.8 ✓	Inner					
3	External Relief Depth		11 ✓	11 ✓					
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		6	2	25				

**Inspected By (Sign) & Date**

Ravi 6/25

Saty 6/2/15

Reviewed by (Engineer-CNC)

Manager-QA