



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.		14169 ✓	30/40/21/5
2	Machined By		V.T.L. H/C Shop	Drg. No. Lark 8310
3	Pallet Die No.		13314 (3.2) H/C ✓	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/C, Step OD: 491 H/C	Step length: 12.4
6	Inside Diameter	Drg. No.	420.12 H/C ✓	
7	Width of Pellet Die	Drg. No.	158 H/C ✓	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/C 12 x 8 x 3 H/C ✓	
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 8 Both Side
12	Tapping PCD		454 H/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: 19.3 H/C	Tapping Depth: 16.6 H/C ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 30/7/13

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 Rev: 23
2	External Relief Dia	2.8 H/C	Outside (2-2)	Inner				
3	External Relief Depth		13 H/C	10 H/C				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		30	7	25			

Inspected By (Sign) & Date

Ravi 30/7/13

Satsouli
30/7/13

Reviewed by (Engineer-CNC)

Manager-QA