



# 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.		14231 ✓	38/40 ✓
2	Machined By		V. T. L. n/c Shop	Drg No. = 6.2.6.15-62
3	Pallet Die No.		13316 (3.2) H4 ✓	Rev. no
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H4, Step no. 498.83	Tappet = 12"
6	Inside Diameter	Drg. No.	420.12 H4	Step length = 2.13 H4
7	Width of Pellet Die	Drg. No.	158 H4 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H4   12x8x3 H4 ✓	
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 = 8 Both Side
12	Tapping PCD		454 H4 ✓	
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 H4, Tapping Depth = 16.6 H4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 22/7/13

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° Rov = 23
2	External Relief Dia	3.8 H4	Outside (2-2)		Inner			
3	External Relief Depth		R H4		L H4			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date			22	2	25		

### Inspected By (Sign) & Date

Ravi 22/7/13

Satish 22/7/13

Reviewed by (Engineer-CNC)

Manager-QA