



# 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.		14185 ✓	46/50 ✓
2	Machined By		V. T. L. n/c Shop	Drg. No. L.S. 805
3	Pallet Die No.		19261 (8.0) n/c	R. 200.00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 n/c, Step OD: 491.8 n/c	Step length: 17.5
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c   12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c	Tapping No. of holes: 8 Back side
13	Tapping Hole Diameter		∅316" - Check by 3rd Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.2 n/c	Tapping Depth: 16.5 n/c
16	Perpendicularity of Tapped Hole		Yes	ⓐ
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 27/7/13

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 Bo. 12
2	External Relief Dia	8.5 n/c	outside (2-2)		Inner			
3	External Relief Depth		12 n/c		4 n/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		27	2	25			

Inspected By (Sign) & Date Ravi 27/7/13

Reviewed by (Engineer-CNC) [Signature] 27/7/13

Manager-QA