



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10146	30/40/79
2	Machined By		V.T.L. H/C Shop	Drg. No. 1.80.79
3	Pallet Die No.		10386 (6.0) H	Rev. 2.01
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1008 H Step OD 1023 H Tappers 8	
6	Inside Diameter	Drg. No.	850.12 H	Step length 4 H
7	Width of Pellet Die	Drg. No.	266 H	Under 6.0 2.0 H
8	Grooves as per Drawing	Drg. No.	45x8x10 H / 45x8x10 H (8x10) H step 8 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Fore Side Back Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping dia
12	Tapping PCD		935 H	of holes 2
13	Tapping Hole Diameter		H2 3/4 Check by H2 Ball	Back Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 42.2 H Tapping Depth 40 H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/7/13

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

Counter 30°

1	Counter Sinking Depth & Finish	OK						Ravi 16
2	External Relief Dia	6.5 H / 7.0 H	6.5 H All Lines	7.0 H All Lines				
3	External Relief Depth		49 H	39 H				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							Ravi
6	Material Sent For Hardening On Date		8	9	23			Lark Furnace

Inspected By (Sign) & Date

Ravi 31/7/13

Reviewed by (Engineer-CNC)

Manager-QA