



# 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.		9791	40/40
2	Machined By		V.T.L. N/c Shop	Dry Run Lark 9795
3	Pallet Die No.		9797 (4.5) M4	9790
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 M4	Step OD = 491 M4
6	Inside Diameter	Drg. No.	420.12 M4	Step length 7.4
7	Width of Pellet Die	Drg. No.	158 M4	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 M4   12 x 8 x 3 M4	
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 M4	Tapping No. of Holes: 8 Both Side
13	Tapping Hole Diameter		M2 x Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 28.8 M4	Tapping Depth = 16.8 M4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 28/6/13	
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	
<b>Note :</b> Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Row = 18
2	External Relief Dia	5.0 M4	outside (2-2)	
3	External Relief Depth		4 M4	Innen Null
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		28	6 23
Inspected By (Sign) & Date			Ravi 28/6/13	

Reviewed by (Engineer-CNC)

Manager-QA