



# 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.		10514	30/00
2	Machined By		V.T.L. n/c Shop	Drg No. L.S.D. 054
3	Pallet Die No.		10916 (G.O) n/c	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	7.20 n/c Step OD = 6.92 n/c	Step length = 19.5 n/c
6	Inside Diameter	Drg. No.	6.00.12 n/c	
7	Width of Pellet Die	Drg. No.	2.22 n/c	
8	Grooves as per Drawing	Drg. No.	36x10x7 n/c   36x10x7 n/c	
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 = 12 Both Side
12	Tapping PCD		64.5 n/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 = 20.4 n/c Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 31/11/13

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						Rev 216
2	External Relief Dia	7.0 n/c	7.0 n/c	all lines				
3	External Relief Depth		30 n/c					
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Forance
6	Material Sent For Hardening On Date		2	11	23			

Inspected By (Sign) & Date Ravi 31/11/13

Reviewed by (Engineer-CNC) Saty 2/11/13

Manager-QA