

	Lark Engineering Co. (India)		Form No.	CNC/QA/FM/02
	ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (Haryana)		Rev. No.	01
	Inprocess Inspection (Pellet Dies)		Rev. Date	31.07.2013

S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10603	55/00
2	Machined By		V. T. L. n/c Shop	Drg No. L.B. 9. 312
3	Pellet Die No.		10995 (3.5) n/c	Rev. 00
4	Die category	Dr. No.	Jumbo	
5	Outside diameter	Dr. No.	780 n/c / Step OD, 792 n/c	Step length = 37 n/c
6	Inside Diameter	Dr. No.	660.12 n/c	Under cut = 8 n/c
7	Width Of Pellet Die	Dr. No.	324 n/c	
8	Grooves As Per Drawing	Dr. No.	21.5 x 8 x 12 n/c / 21.5 x 8 x 12 n/c	
9	Fitting Sizes on CNC Plate	Dr. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping used Hole 12 Both Side
12	Tapping PCD		725 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 31.4 n/c	Tapping Depth 29.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 4/12/13

1	As per programme no.		_____	2 Slot 32 n/c width 8 n/c Deep Both Side
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. 51
2	External Relief Dia.	4.0 n/c	outside 7.3-7.5 Inner	
3	External Relief Depth		12 n/c 5 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purvace	
6	Material Sent For Hardening On Date		4/12/13	

Inspected By (Sign) & Date Ravi 4/12/13


 Reviewed by (Engineer (CNC))

Manager-QA