



# 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.		10868	40/50
2	Machined By		V.T.L. H/C Shop	8355 Dry No. Lark 3510
3	Pallet Die No.		11091 (4.0) H/C	
4	Die Category	Drg. No.	Extenside	
5	Out Side Diameter	Drg. No.	620 H/C Step OD = 612 H/C Step length = 19.5 H/C	
6	Inside Diameter	Drg. No.	520.12 H/C	
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C / 13x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		M202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.3 H/C Tapping Depth 19.1 H/C	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 12/12/13	
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		Row = 31
2	External Relief Dia	4.3 H/C	Outside (3-3)	Inner
3	External Relief Depth		14 H/C	10 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		12	12 23
Inspected By (Sign) & Date			Ravi 12/12/13	

Review

*Signature*  
12/12/13

Reviewed by (Engineer-CNC)

Manager-QA