



# 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.		10908	40/40
2	Machined By		V. T. L. M/c Shop	5195 Dy. M/c Lark SS10
3	Pallet Die No.		10733 (4.0) M/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 M/c Shop OD = 491 M/c	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 M/c	
7	Width of Pellet Die	Drg. No.	158 M/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 M/c   12x8x3 M/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454 M/c	
13	Tapping Hole Diameter		M2x2 Check by M2x2 Bolt	Tapping dia of hole is 2 Both side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.2 M/c Tapping Depth 17.2 M/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 18/12/13

1 As per programme no.

2 Gun Drilling Work Completed On

3 Hole Finish In Gun Drilling

Marked

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

2 External Relief Dia

4.5 M/c

outside (2-2)

Innen

3 External Relief Depth

4 M/c

Nil

4 Inspection Done Before Hardening By (Name)

Ravi

5 Material Sent For Hardening By (Name)

Lark Parnace

6 Material Sent For Hardening On Date

18

10

23

### Inspected By (Sign) & Date

Ravi 18/12/13

Reviewed by (Engineer-CNC)

Manager-QA