



# 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.		10909	
2	Machined By		V.T.L. n/c ✓ step	92/50
3	Pallet Die No.		11089 (2.8) n/c ✓	Drg Nos Lark 3310
4	Die Category	Drg. No.	Ext 2 side	
5	Out Side Diameter	Drg. No.	620 n/c ✓ step OD = 612 n/c ✓	Step length = 19.5
6	Inside Diameter	Drg. No.	520.12 n/c ✓	
7	Width of Pellet Die	Drg. No.	229 n/c ✓	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 n/c ✓   13 x 8 x 5 n/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c ✓ step	
12	Tapping PCD		565 n/c ✓	Tapping No. of Holes = 12 Both Side
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 = 12.3 n/c ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 29/12/13

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

Counter = 60°

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.3 n/c ✓	outside (3-3)		Inner				
3	External Relief Depth		25 n/c ✓		22 n/c ✓				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		29	12	23				

### Inspected By (Sign) & Date

Ravi 29/12/13

Reviewed by (Engineer-CNC)

Manager-QA