



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.		10996	
2	Machined By		V.T.L H/c Shop	39/42/50/ 6555
3	Pallet Die No.		11077 (410) H/c	Dy. No. Lark 3370
4	Die Category	Drg. No.	External	
5	Out Side Diameter	Drg. No.	620 H/c	
6	Inside Diameter	Drg. No.	Step 002 612 H/c	Step length 19.5
7	Width of Pellet Die	Drg. No.	520.12 H/c	
8	Grooves as per Drawing	Drg. No.	222 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c	Tapping No. of Hole = 12 Botu 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 = 21.2 H/c	Tapping Depth = 18.3 H/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

1	Counter Sinking Depth & Finish	ok								Ravi 31
2	External Relief Dia	4.5 H/c / 5.0 H/c	4.5 H/c	All Lines	5.0 H/c	All Lines				
3	External Relief Depth		18 H/c		8 H/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		28	12	23					

Inspected By (Sign) & Date

Ravi 29/12/13

Reviewed by (Engineer-CNC)

Manager-QA