



# 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.		11133	120/120
2	Machined By		V.T.L n/c Shop	Digital I.S.O. 559
3	Pallet Die No.		11533 (3.5) n/c	Rev: 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	870 n/c, Step OD: 743.4 n/c	Tappet = 10
6	Inside Diameter	Drg. No.	630.12 n/c / 630.14 n/c (B)	Step length = 23 n/c
7	Width of Pellet Die	Drg. No.	265 n/c	
8	Grooves as per Drawing	Drg. No.	15x8x5 n/c / 15x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No of holes = 16 Both Side
12	Tapping PCD		685 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: 21.4 n/c Tapping Depth: 19 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 1/2/14

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 - 1 Hole Colored (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok							Rev = 38
2	External Relief Dia	_____	_____	_____	_____	_____	_____	_____	_____
3	External Relief Depth	_____	_____	_____	_____	_____	_____	_____	_____
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Keshav
6	Material Sent For Hardening On Date								1 2 24
Inspected By (Sign) & Date		Ravi 1/2/14							

1/2/14

Reviewed by (Engineer-CNC)

Manager-QA