



# 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.		11320	48/50
2	Machined By		V. T. L. n/c Shop	Dy No. (200) 998
3	Pallet Die No.		11626 (4.5) mm	Reason
4	Die Category	Drg. No.	End outside	
5	Out Side Diameter	Drg. No.	620.1 mm Step 00.2 Tabber, 12° Step length	
6	Inside Diameter	Drg. No.	520.12 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm   13x8x5 mm	
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 = 12 Back side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20.2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 81 mm Tapping Depth 19 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 21/7/14

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

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

Completed 800  
Reason 29

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	5.0 mm	Outside (3-3)	Inner			
3	External Relief Depth		13 mm	8 mm			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		21	2	24		

**Inspected By (Sign) & Date**

Ravi 21/7/14

Reviewed by (Engineer-CNC)

Manager-QA