



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		INV ✓	31/07/13
3	Pallet Die No.		Y.T.L. n/c Shop	Dynator Lark SS10 ✓
4	Die Category	Drg. No.	10950 (2.8) n/c	
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	499.8 n/c, Step OD: 490.8 n/c	Step length: 17.4 ✓
7	Width of Pellet Die	Drg. No.	420.12 n/c	
8	Grooves as per Drawing	Drg. No.	158 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 n/c 12 x 8 x 3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of Holes: 8 Roth Side
13	Tapping Hole Diameter		454 n/c	
14	Tapping On Second Side	Half pitch of 1st side	M20 - Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 19.8 n/c	Tapping Depth: 17.2 ✓
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 13/8/13

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	3.1MM	Outside (2-2)	Inner					Rep: 20
3	External Relief Depth	✓	15MM	9MM					
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		13	9	24				

Inspected By (Sign) & Date

Ravi 12/8/13

Reviewed by (Engineer-CNC)

Manager-QA