



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

7009

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11356	31/47
2	Machined By		V.T.L n/c Shop	Dry No. 1.8.02875
3	Pallet Die No.		11722 (2.8) n/c	Rev 2.00
4	Die Category	Drg. No.	Partswide	ⓐ
5	Out Side Diameter	Drg. No.	614 n/c / 3 step 60, 623.7 n/c	Topper 12
6	Inside Diameter	Drg. No.	520.12 n/c	Step length 12 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	Undercut = 4.3 n/c
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/c	Tapping n/c of hole 12
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21 n/c Tapping Depth 18.7 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 26/7/14

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 - 2 Hole Closed ⓐ

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

		Counter Bore				Row 40	
1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	33 n/c	Outside (3-3)	Inner			
3	External Relief Depth	22 n/c		16 n/c			
4	Inspection Done Before Hardening By (Name)	Ravi					
5	Material Sent For Hardening By (Name)	Lark Formace					
6	Material Sent For Hardening On Date	26	2	24			
Inspected By (Sign) & Date		Ravi 26/7/14					

Reviewed by (Engineer-CNC)

Manager-QA