



# 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.		9920	36/40
2	Machined By		V.T.L. n/c Shop	Drg No. 2195 Lark 9310
3	Pallet Die No.		9809 (4.0) 44	✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm Step 002 491mm	Step length 15.4
6	Inside Diameter	Drg. No.	420.12mm	Ⓟ
7	Width of Pellet Die	Drg. No.	1578mm Ⓟ	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 11.3x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Ⓟ ✓
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454mm	Tapping No. of holes @ Both Side
13	Tapping Hole Diameter		N20 ✓ Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4mm	Tapping Depth 16.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 18/7/13

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 20
2	External Relief Dia	4.3mm	Outside (2-2)		Inner				
3	External Relief Depth	✓	8mm		4mm				
4	Inspection Done Before Hardening By (Name)								Ravi ✓
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		18	7	23				

Inspected By (Sign) & Date

Ravi 18/7/13

Reviewed by (Engineer-CNC)

Manager-QA