



# 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.		9639	27/42
2	Machined By		V.T.L n/a Shop	Drg No. 1-3.0 = 54
3	Pallet Die No.		10208 (3.0) n/a	Rev. 00
4	Die Category	Drg. No.	N. Jumbo	✓
5	Out Side Diameter	Drg. No.	694 n/a Step OD = 693 n/a	Tappe = 12°
6	Inside Diameter	Drg. No.	600.12 n/a	Step length = 20 n/a
7	Width of Pellet Die	Drg. No.	222 n/a	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 7.5 n/a   12 x 10 x 7.5 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/a Shop	
12	Tapping PCD		64 n/a	[ Tapping No of holes = 12 Back Side ]
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 20.4 n/a Tapping Depth 18-8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Rao: 10/6/13

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 - 1 hole Colored (A)

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

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	3.5 n/a	outside (3-3)		inner				
3	External Relief Depth		23 n/a		20 n/a				
4	Inspection Done Before Hardening By (Name)				Rao				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date				10 6 23				

Inspected By (Sign) & Date Rao: 10/6/13

Reviewed by (Engineer-CNC)

Manager-QA