



# 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.		9959	55/55
2	Machined By		V.T.L N/C Shop	Dr. H. S. O. 407
3	Pallet Die No.		9711 (4.0) H	Rev. 200
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	Hony Step OD = 699 H	Step length 80 H
6	Inside Diameter	Drg. No.	600.12 H	
7	Width of Pellet Die	Drg. No.	222 H	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 H   12 x 8 x 7 H	
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 Both side
12	Tapping PCD		640 H	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 22/7/13

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 22
2	External Relief Dia	6.5 H	Outside (3-3)		Inner					
3	External Relief Depth	✓	5 H		Nil					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Porner
6	Material Sent For Hardening On Date		22	7	23					

Inspected By (Sign) & Date

Ravi 22/7/13

Reviewed by (Engineer-CNC)

Manager-QA