



# 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.		9899	3250
2	Machined By		V. T. L. M/c Shop	30/50
3	Pallet Die No.		10211 (4.0) M	3977
4	Die Category	Drg. No.	H. Jumbo	Rev 209
5	Out Side Diameter	Drg. No.	700 M	Final fitting size Drg No 345
6	Inside Diameter	Drg. No.	600.2 M	Step length 19.5
7	Width of Pellet Die	Drg. No.	888 M	
8	Grooves as per Drawing	Drg. No.	15x8x7 M	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		64 M	Tapping No of holes 12 Both Side
13	Tapping Hole Diameter		M2.2 Check by M20 B.12	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 M	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 29/7/13

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 31
2	External Relief Dia	4.3 M	OK side (3-3)		Inner					
3	External Relief Depth	✓	22 M		18 M					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Porname					
6	Material Sent For Hardening On Date		29	7	23					

### Inspected By (Sign) & Date

Ravi 29/7/13

Reviewed by (Engineer-CNC)

Manager-QA