



# 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

Rev. Date

31-07-2013

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		10050 12610	30/08/00
3	Pallet Die No.		V.T.C. n/c Shop	Dy. - G.S.N. 728
4	Die Category	Dr. No.	12848(4.0) n/c	Rev: 00
5	Out Side Diameter	Dr. No.	Jumbo	
6	Inside Diameter	Dr. No.	780 n/c Shop	Step length 28.5
7	Width of Pellet Die	Dr. No.	660.12 n/c	Under cut 6mm
8	Grooves as per Drawing	Dr. No.	324 n/c	
9	Fitting Sizes on CNC Plate	Dr. No.	21.5 x 8 x 8 n/c	21.5 x 8 x 8 n/c
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping n/c of Hole 2
13	Tapping Hole Diameter		725 n/c	Both Side
14	Tapping On Second Side	Half pitch of 1st side	M20 Check by M20 Plug	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 31 n/c	Tapping Depth 29.4
17	Visual Inspection Before Gun Drilling		yes	
			ok	

### Inspected By (Sign) & Date

Sasi 22/8/14

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

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

1	Counter Sinking Depth & Finish	OK					Counter 2
2	External Relief Dia	4.8 n/c / 5.0 n/c	4.8 n/c All Rows	5.0 n/c All Rows			Row 24
3	External Relief Depth		30 n/c	22 n/c			
4	Inspection Done Before Hardening By (Name)		Sasi				
5	Material Sent For Hardening By (Name)		Lark Barra				
6	Material Sent For Hardening On Date		22	8	24		

### Inspected By (Sign) & Date

Sasi 22/8/14

Sasi 22/8/14

Reviewed by (Engineer-CNC)

Manager-QA