

# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

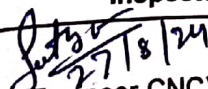
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Rev. Date

31-07-2013

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12767 ✓	40/40 ✓
2	Machined By		V.T.L M/c Shop	Dwg No - LEC 1506P
3	Pallet Die No.		11836 (4.5mm) ✓	(REV 00) ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm ✓	Step length - 18mm
6	Inside Diameter	Drg. No.	420.12mm ✓	Taper - 12° ✓
7	Width of Pellet Die	Drg. No.	158mm ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	
10	Drilling Area Surface Smoothness		OK	[ Tapping No. of Holes 8 Both Side ]
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454mm ✓	
13	Tapping Hole Diameter		M70 Check by M70 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 18.4mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ramanpreet Singh 27/08/14	Convert from TAPER to St. after hardening
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	
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	OK		Counter - 60° Row - 18
2	External Relief Dia	5.0mm	Outside (P-P) Innel	
3	External Relief Depth		5mm 0 ✓	
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		27 08 24	
Inspected By (Sign) & Date			Ramanpreet Singh 27/08/14	

Reviewed by (Engineer-CNC)  
 27/8/14

Manager-QA