



# 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.		10089	66/70
2	Machined By		V.T.L. n/c Shop	Drg No. 1.8C2861
3	Pallet Die No.		5469 (4.0) n/c	Rev: 00
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1040 n/c	Step length 38 n/c
6	Inside Diameter	Drg. No.	900.12 n/c	Tapker 3°
7	Width of Pellet Die	Drg. No.	375 n/c	
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	29.5 x 8 x 13 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		970 n/c	Tapping No. of Holes - 15 Both Side
13	Tapping Hole Diameter		M24 Check by M24 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 38.5 n/c	Tapping Depth 35.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Raw: 11/8/13

1	As per programme no.			2 Slot 32.1 n/c width 7.5 n/c Depth Both Side
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No	

As per programme dies supplied

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

1	Counter Sinking Depth & Finish	ok								Rev: 53
2	External Relief Dia	6.5 n/c	Outside (4-4)		Inner					
3	External Relief Depth		13 n/c		5 n/c					
4	Inspection Done Before Hardening By (Name)									Raw
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date			11	8	23				

### Inspected By (Sign) & Date

Raw: 11/8/13

Raw: 11/8/13

Reviewed by (Engineer-CNC)

Manager-QA