



# 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		13483/	34/60/
3	Pallet Die No.		V.T.L. H/c Shop	Drill No. 130-111
4	Die Category	Drg. No.	13820 (4.0) H/c	Rev. 00
5	Out Side Diameter	Drg. No.	Jumbo	
6	Inside Diameter	Drg. No.	780 H/c Step 00 = 790 H/c Step length 265	
7	Width of Pellet Die	Drg. No.	660.12 H/c	Under cut 6mm
8	Grooves as per Drawing	Drg. No.	324 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 8 H/c / 21.5 x 8 x 8 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping No. of holes = 12 Both Side
13	Tapping Hole Diameter		725 H/c	
14	Tapping On Second Side	Half pitch of 1st side	M20 = Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 31.3 H/c Tapping Depth = 29.6	
17	Visual Inspection Before Gun Drilling		yes ok	

### Inspected By (Sign) & Date

Ravi 6/24

1	As per programme no.			2 slot 39.1 H/c width 8 H/c Deep Both Side
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No - 2 Hole Closed	

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

Counter = 60  
Low = 46

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.8 H/c	outside (2-3)		Inner		
3	External Relief Depth		30 H/c		26 H/c		
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark For case			
6	Material Sent For Hardening On Date		6	12	24		

### Inspected By (Sign) & Date

Ravi 6/24

Reviewed by (Engineer-CNC)

Manager-QA