



# 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.		12697	33/53/79
2	Machined By		V. T. L. n/c Shop	Dy. No. 1202/17
3	Pallet Die No.		12967 (G.O) n/c	Rev. 2.01
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1008 n/c, Step OD = 1023 n/c	Tapber, 8°
6	Inside Diameter	Drg. No.	850.1 n/c	Step length 41 n/c
7	Width of Pellet Die	Drg. No.	266 n/c	Under cut 2.44 n/c
8	Grooves as per Drawing	Drg. No.	45x8x10 n/c / 45x8x10 n/c	(8x10)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[ Face Side Step 2 n/c Back Back Side ]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		935 n/c	[ Tapping No of Holes 2 Back Side ]
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 42.2 n/c	Tapping Depth 40 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 12/12/14	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		N.	
Note : Mark the defective holes/missed holes with the help of Permanent Marker				Counter 30
1	Counter Sinking Depth & Finish	ok		Rev 2.16
2	External Relief Dia	6.5 n/c / 7.0 n/c	6.5 n/c All Rows 2 46 n/c	
3	External Relief Depth		7.0 n/c All Rows 2 28 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purvace	
6	Material Sent For Hardening On Date		12 13 24	
Inspected By (Sign) & Date			Ravi 12/12/14	

Reviewed by (Engineer-CNC)

Manager-QA