



# 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.		13503	60/65.5
2	Machined By		V.T.L. n/c Shop	Drg. No. 13.029-3
3	Pallet Die No.		14078 (12.0) n/c	Rev. 03
4	Die Category	Drg. No.	SSS10	
5	Out Side Diameter	Drg. No.	639.7 n/c Step 00. 652.2 n/c	Tapper: 8°
6	Inside Diameter	Drg. No.	508.9 n/c (1D Step - 539.7 n/c / 523.28 n/c)	Step length: 33 n/c
7	Width of Pellet Die	Drg. No.	175 n/c	
8	Grooves as per Drawing	Drg. No.	30x21x7.20 n/c / 9x25 n/c	Face Side Step 0.5 n/c Deep
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c gules - 4
12	Tapping PCD		574 n/c	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 2nd Side 48.0	
15	Tapping Hole Depth		Drill Depth: 30.3 n/c Tapping Depth: 28.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 18/12/14	48.0
1	As per programme no.		—	51.5 n/c Long 28.1 n/c width 15 n/c Deep
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°
2	External Relief Dia	12.5 n/c	All Rows	Row 25
3	External Relief Depth		5.5 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		18 12 24	
Inspected By (Sign) & Date			Ravi: 18/12/14	

Reviewed by (Engineer-CNC)

Manager-QA