



# 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.		13473	49/50
2	Machined By		V.T.L H/C Shop	Drg No. L.S. 01015
3	Pallet Die No.		12770 (8.0) H/H	Rev. 4.0
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	418 H/H, Step 00.2 383 H/H	Step length 10.4 H/H
6	Inside Diameter	Drg. No.	318.12 H/H / 320.12 H/H (Bore 318.12)	
7	Width of Pellet Die	Drg. No.	108 H/H	
8	Grooves as per Drawing	Drg. No.	4x5x3 H/H / 4x5x3 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		350 H/H	Tapping H/D of holes = 8 Back Side
13	Tapping Hole Diameter		OK	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 12.4 H/H	Tapping Depth 10.5 H/H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi: 19/12/14

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		No

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

1	Counter Sinking Depth & Finish	OK						Counter 60°
2	External Relief Dia	8.5 H/H	Outside (2-2)		Inner			Lower 8
3	External Relief Depth		12 mm		8 mm			
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: 19/12/14

Reviewed by (Engineer-CNC)

Manager-QA