



# 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.		13790	37/47
2	Machined By		V.T.L. H/c Shop	Drg. No. 1.8.0.875
3	Pallet Die No.		13696(3.0) H/c	Rev. 2.00
4	Die Category	Drg. No.	Extrusion Die	
5	Out Side Diameter	Drg. No.	614 H/c	Step CD = 62.5 H/c
6	Inside Diameter	Drg. No.	52.0 H/c	Tapper 12°
7	Width of Pellet Die	Drg. No.	22.8 H/c	Step length 18 H/c
8	Grooves as per Drawing	Drg. No.	22.8 H/c	Under cut 4.3 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		56.5 H/c	Tapping No of Holes = 12 Both side
13	Tapping Hole Diameter		H20	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H/c	Tapping Depth 18 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 11/25

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

Counter 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	3.5 H/c	outside (2-3)		Inner					
3	External Relief Depth		16 H/c		10 H/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									Lark Formac
6	Material Sent For Hardening On Date									25

### Inspected By (Sign) & Date

Ravi 11/25

Reviewed by (Engineer-CNC)

Manager-QA