



# 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.		13573 ✓	33/50
2	Machined By		V.T.L. H/C Shop	Drg. No. 130.781
3	Pallet Die No.		14089 (4.0) H/C ✓	Rev. No. ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 H/C, Step 00, 498.88	Tapper, 12°
6	Inside Diameter	Drg. No.	420.12 H/C	Step length 18 H/C
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C   12x8x3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		454 H/C	Tapping H/C of holes = 8 Both Side
13	Tapping Hole Diameter		H20 = Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.2 H/C	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 31/125

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	4.5 H/C	Outside 2-25		Inner		Rev 2 20
3	External Relief Depth		16 H/C		12 H/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		3	1	25		

### Inspected By (Sign) & Date

Ravi 31/125

Reviewed by (Engineer-CNC)

Manager-QA