



# 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.		13717	53/55
2	Machined By		V.T.L. H/c Shop	Qty No. 6302 228
3	Pallet Die No.		13579(4.5) H/c	Rev. 05
4	Die Category	Drg. No.	2nd side	
5	Out Side Diameter	Drg. No.	630 H/c Step 00. 615.5 H/c	Tabber 4"
6	Inside Diameter	Drg. No.	520.12 H/c	Step length 90 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 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		565 H/c	Tapping No of holes = 12 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 = 20.2 H/c Tapping Depth = 18.5 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 31/25

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

1	Counter Sinking Depth & Finish	OK							Counter = 60° Ravi 29
2	External Relief Dia	5.0 H/c	Outside (3-3)		Inner				
3	External Relief Depth		9 H/c		2 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 31/25

Reviewed by (Engineer-CNC)

Manager-QA