



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13763	19/66
2	Machined By		V.T.L n/c Shop	Dy No. 18.26-9
3	Pallet Die No.		13999 (6.0) n/c	Row 2 03
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 n/c	Step 05: 692.8 n/c, Tapper 8
6	Inside Diameter	Drg. No.	546.12 n/c	(Bor: 548.3 n/c) Step length: 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Wden cot: 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 n/c	32 x 7 x 9.2 n/c (4 x 8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face side step
11	Tapping Operator		n/c Shop	2 n/c Deep Bolt
12	Tapping PCD		819 n/c	Side
13	Tapping Hole Diameter		M16	Tapping No. of holes - 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Bottom Side
15	Tapping Hole Depth		Drill Depth: 33.2 n/c	Tapping Depth: 3.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 31/7/13

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 30
2	External Relief Dia	4.5 n/c		All Rows					Row 2 12
3	External Relief Depth			47 n/c					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lanka Furnace					
6	Material Sent For Hardening On Date			8	1	25			

### Inspected By (Sign) & Date

Ravi 31/7/13

Reviewed by (Engineer-CNC)

Manager-QA