



# 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.		13741	32/50
2	Machined By		V.T.L. HLC Shop	Dy No. 1.3.024/19
3	Pallet Die No.		12878(4.0) HLC	Rev: 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 HLC	Step OD: 692 HLC
6	Inside Diameter	Drg. No.	600.12 HLC	Step length: 13.5
7	Width of Pellet Die	Drg. No.	222 HLC	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 HLC	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		HLC Shop	
12	Tapping PCD		645 HLC	Tapping of holes 12 Bolt Side
13	Tapping Hole Diameter		M20 2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 22.2 HLC	Tapping Depth: 20 HLC
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 7/12/13

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: 60
2	External Relief Dia	4.5 HLC	outside (3-3)		Inner		Rev: 32
3	External Relief Depth		22 HLC		18 HLC		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark furnace		
6	Material Sent For Hardening On Date		7	1	25		

### Inspected By (Sign) & Date

Ravi 7/12/13

Reviewed by (Engineer-CNC)

Manager-QA