



# 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.		13758 ✓	45/66 ✓
2	Machined By		V.T.L. M/c Shop	Dry No. 130809
3	Pallet Die No.		14001 (80) M/c ✓	Rev. 03 ✓
4	Die Category	Drg. No.	for H. Tombu	
5	Out Side Diameter	Drg. No.	680.7 M/c ✓	Step 005 693 M/c ✓
6	Inside Diameter	Drg. No.	546.12 M/c (Bore: 548.3 M/c)	Step Length 3 M/c ✓
7	Width of Pellet Die	Drg. No.	195 M/c ✓	Undercut 2.5 M/c ✓
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 M/c   32 x 7 x 9.2 M/c	(4 x 8) M/c ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 M/c Deep Bore
11	Tapping Operator		M/c Shop	Side
12	Tapping PCD		619 M/c ✓	Tapping No
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	of Hole, 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Bore Side
15	Tapping Hole Depth		Drill Depth 33 M/c	Tapping Depth 31.5 M/c ✓
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 Bore
2	External Relief Dia	9.0 M/c ✓	All Rows					Low, 10
3	External Relief Depth		21 M/c ✓					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Forge					
6	Material Sent For Hardening On Date		8	1	25			

### Inspected By (Sign) & Date

Ravi 31/7/13

Satish 08/11/13

Reviewed by (Engineer-CNC)

Manager-QA