



# 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

8932

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13741	32/50
2	Machined By		V.T.C n/c stop	Drg No. 1:30-419
3	Pallet Die No.		12877 (4.0) n/c	Rev 200
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	899.8 n/c	Step OD: 692 n/c, Step length: 17.5
6	Inside Diameter	Drg. No.	600.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 n/c / 12.5 x 3 x 7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c stop	Tapping No. of Holes, 12 Both Side
12	Tapping PCD		645 n/c	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 22.2 n/c	Tapping Depth 20.5
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

Counter = 60

Rev = 32

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5 n/c	outside (3-3)		Inner		
3	External Relief Depth		22 n/c		18 n/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			08	1	25	

### Inspected By (Sign) & Date

Ravi 31/7/13

Ravi 31/7/13

Reviewed by (Engineer-CNC)

Manager-QA