

9055



# 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.		13935 ✓	63/66 ✓
2	Machined By		V.T.L. H/c Shop	Dy. No. 1.3.0-809
3	Pallet Die No.		14007 (10.0) H/c	Rev = 03
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 H/c 3 Step 05. 692.8 H/c	Topper = 8
6	Inside Diameter	Drg. No.	1548.12 H/c (Bore 548.3 H/c)	Step length = 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut = 2.5 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 H/c	(4 x 7.9 H/c)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Rch 2 H/c Deep Both Side Tapping No of Holes = 2 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 H/c	
13	Tapping Hole Diameter		HIG 2 Check by HIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.3 H/c	Tapping Depth = 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 23/1/12

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 = 6 Row = 8
2	External Relief Dia	11.0 H/c	All Rows					
3	External Relief Depth		3 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		23	1	25			

### Inspected By (Sign) & Date

Ravi 23/1/12

Satish 23/1/12

Reviewed by (Engineer-CNC)

Manager-QA