



# 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)

9303

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14286 ✓	45/55 ✓
2	Machined By		V.T.L M/C Shop	Dr. No. 18.02.09
3	Pallet Die No.		11497 (4.5) ✓	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	710mm, Step 00, 703mm	Tapper 4°
6	Inside Diameter	Drg. No.	600.12 mm	Step length 28mm
7	Width of Pellet Die	Drg. No.	250mm ✓	
8	Grooves as per Drawing	Drg. No.	24x5x9mm / 24x5x9mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No. of holes 12 Back Side
12	Tapping PCD		655mm ✓	
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 24.2mm	Tapping Depth 22.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 27/7/13

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°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	5.0mm ✓	Outside (3-3)		Inner					
3	External Relief Depth		15mm		10mm					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark For race
6	Material Sent For Hardening On Date			27	2	25				

### Inspected By (Sign) & Date

Ravi 27/7/13

Reviewed by (Engineer-CNC)

Manager-QA