

9314



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.		14273 ✓	34/50 ✓
2	Machined By		V.T.L. H/c Shop	Drg No. Lark 9310
3	Pallet Die No.		14167 (4.0) H/c ✓	
4	Die Category	Drg. No.	Extrusion Die	
5	Out Side Diameter	Drg. No.	620 H/c, Step 00. 612 H/c	Step length 18.5
6	Inside Diameter	Drg. No.	520.12 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of holes 12 Beta Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20 x Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 28/7/13

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 Bores

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 H/c	Outside 3-37		Inner				
3	External Relief Depth		20 H/c		16 H/c				
4	Inspection Done Before Hardening By (Name)				Raw:				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		28	2	25				

Inspected By (Sign) & Date

Raw: 28/7/13

Reviewed by (Engineer-CNC)

Manager-QA