



# 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)

6328

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10410 ✓	38 / 65-50
2	Machined By		N.T.L. N/c Shop	Drg Nos L.S. 02-9.2
3	Pallet Die No.		11164 (8.0) mm	Rev 00
4	Die Category	Drg. No.	58870 ✓	
5	Out Side Diameter	Drg. No.	641.7 mm	Step 00, 852.3 mm Tapper: 8°
6	Inside Diameter	Drg. No.	508.8 mm / ID Step = 539.7 / 593.35	Step length = 39 mm
7	Width of Pellet Die	Drg. No.	175 mm	
8	Grooves as per Drawing	Drg. No.	9x25 mm / 30x21x9 mm	Fore side step 05 mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/c Shop	
12	Tapping PCD		574 mm	Tapping No. of Holes: 4
13	Tapping Hole Diameter		NIG - Check by NIG Belt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and	Ind Side Slot
15	Tapping Hole Depth		Drill Depth: 30.4 mm	Tapping Depth: 28.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 27/10/13

1	As per programme no.		_____	4 Slot 50 mm long 28 mm wide 15 mm Deep
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							Row: 8
2	External Relief Dia	9.5 mm	9.5 mm	All Lines					
3	External Relief Depth			27.5 mm					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Porrace					
6	Material Sent For Hardening On Date		27	10	23				

### Inspected By (Sign) & Date

Ravi 27/10/13

Satish 27/10/13

Reviewed by (Engineer-CNC)

Manager-QA