



# 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.		10535	32/40
2	Machined By		V.T.L. w/c Shop	Drg No. 1-80, 881
3	Pallet Die No.		10347 (3.5) mm	Reo 50
4	Die Category	Drg. No.	38W	
5	Out Side Diameter	Drg. No.	500 mm Step OD = 490.7 mm	Step length 16.5
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	173 mm	
8	Grooves as per Drawing	Drg. No.	12x10x5 mm / 12x10x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No of holes 8 Both Side
12	Tapping PCD		455 mm	
13	Tapping Hole Diameter		Ø3/4" checked by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21 mm Tapping Depth = 19 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi Jul 23

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								Ravi = 24
2	External Relief Dia	4.0 mm	Outside (2-2)		Innen					
3	External Relief Depth		12 mm		8 mm					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		7	11	23					

### Inspected By (Sign) & Date

Ravi Jul 23

Reviewed by (Engineer-CNC)

Manager-QA