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# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10917	48/50
2	Machined By		V.T.L. H/C Shop	Dy. No. 1302-493
3	Pallet Die No.		9977 (4.0) H/C	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/C Step 002 693 H/C	Tapper 12°
6	Inside Diameter	Drg. No.	600.12 H/C	Step length 2 H/C
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 H/C / 12x10x7.5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping H. of 1.162 = 12 Bolt Side
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		M22 Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 213 H/C Tapping Depth 19 H/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi Shrivastava

1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		ok	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 H/C	outside 2-3		inner 2 H/C				
3	External Relief Depth		10 H/C						
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Fornace				
6	Material Sent For Hardening On Date		21	12	25				

Inspected By (Sign) & Date

Ravi Shrivastava

Reviewed by (Engineer-CNC)

Manager-QA