



# 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.		10975 ✓	21/40
2	Machined By		V.T.L. H/c Shop	Dy. Insp. (S.O.) 177
3	Pallet Die No.		10405 (3.2) H/c	2002 00
4	Die Category	Drg. No.	5810	
5	Out Side Diameter	Drg. No.	500 H/c, Step 0.0, Tapper 12° S depth length 17.5	
6	Inside Diameter	Drg. No.	420.14 H/c	
7	Width of Pellet Die	Drg. No.	182 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x4 H/c   13x8x4 H/c	
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 H/c	
13	Tapping Hole Diameter		0.34" - Check by 0.34" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 22 H/c Tapping Depth = 20 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 26/12/13

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

1	Counter Sinking Depth & Finish	ok					Counter 60°
2	External Relief Dia	3.8 H/c	outside (2-2)	Inner			28
3	External Relief Depth		22 H/c	19 H/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		26	12	23		

### Inspected By (Sign) & Date

Ravi 26/12/13

Reviewed by (Engineer-CNC)

Manager-QA