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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
Rev. Date	31-07-2013

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10910	50/55
2	Machined By		V.T.L H/C Shop	Drig No. 1.8.0.14951
3	Pallet Die No.		11363 (5.0) H/H	Rev. 00
4	Die Category	Drig. No.	Extrusion side	
5	Out Side Diameter	Drig. No.	630 H/H ✓ Step 00, 621.5 H/H	Tapper 12
6	Inside Diameter	Drig. No.	520.14 H/H	Step length 21.5
7	Width of Pellet Die	Drig. No.	222 H/H	
8	Grooves as per Drawing	Drig. No.	13x8x5 H/H   13x8x5 H/H	
9	Fitting Sizes on CNC Plate	Drig. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No of holes, 12 Both Side
12	Tapping PCD		565 H/H	
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21 H/H	Tapping Depth 19 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 23/12/13

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

Counter = 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	5.5 H/H	outside (23-3)		Inner				
3	External Relief Depth		10 H/H		5 H/H				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		23	12	23				

### Inspected By (Sign) & Date

Ravi 23/12/13

Sat 23/12/13

Reviewed by (Engineer-CNC)

Manager-QA