



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

67/18

## Inprocess Inspection (Pellet Dies)

Form No. CNC/QA/FM/02

Rev. No. 01

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10965	35/50
2	Machined By		V.T.I. H/a Shop	By No. 18.0.715
3	Pallet Die No.		10851 (G.5)mm	Find Diff. Angle
4	Die Category	Drq. No.	Subvoid	Step length 21.5
5	Out Side Diameter	Drq. No.	62mm step 00, 62.5mm	Under cut 0.75
6	Inside Diameter	Drq. No.	52.14mm	Tapper 212
7	Width of Pellet Die	Drq. No.	89mm	
8	Grooves as per Drawing	Drq. No.	13285mm / 13285mm	
9	Fitting Sizes on CNC Plate	Drq. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/a Shop	Tapping 212
12	Tapping PCD		565mm	of H/a = 12
13	Tapping Hole Diameter		Use Check by H/a Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth = 19.8mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date				
1	As per programme no.		Pasi 29/12/13	
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		Counters G50
2	External Relief Dia	U.O.M	60 Side (2.3-3)	Round 35
3	External Relief Depth		18mm	
4	Inspection Done Before Hardening By (Name)		Pasi	
5	Material Sent For Hardening By (Name)		Lark Porvaco	
6	Material Sent For Hardening On Date		29 12 23	
Inspected By (Sign) & Date				
			Pasi 29/12/13	

Reviewed by (Engineer-CNC)

Manager-QA