



# 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.		10941	52/55
2	Machined By		V.T.L. n/c Shop	Dy. No. 1.8.2.14934
3	Pallet Die No.		11360 (2.5) mm	Rev. 00
4	Die Category	Drg. No.	Extrusion Die	
5	Out Side Diameter	Drg. No.	630mm Step 002 612mm	Step length = 19.5
6	Inside Diameter	Drg. No.	520.12 mm / 520.14 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping H. of 12dia = 12 Both Side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 mm Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 28/7/13

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							Lower 35
2	External Relief Dia	4.0mm	Outside (3-3)		Inner				
3	External Relief Depth		10mm		3mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Forware
6	Material Sent For Hardening On Date		28	12	23				

Inspected By (Sign) & Date Ravi 28/7/13

Reviewed by (Engineer-CNC)

Manager-QA