



# 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.		10950	
2	Machined By		Y.T.L. H/C Shop	33/50
3	Pallet Die No.		11202 (B.O.) H/H	Drg No. 6-20-978
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	620 H/H / Step 002 Tapper	12° Step length 18.5
6	Inside Diameter	Drg. No.	520.12 H/H	
7	Width of Pellet Die	Drg. No.	222 H/H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H / 13x8x5 H/H	
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: 12 Both Side
12	Tapping PCD		565 H/H	
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 H/H Tapping Depth = 18.8 H/H	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 29/12/13

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

Counters 60°

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	3.5 H/H	Outside (2-3)	Inner				
3	External Relief Depth		23 H/H	17 H/H				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		29	12	23			

### Inspected By (Sign) & Date

Ravi 29/12/13

Reviewed by (Engineer-CNC)

Manager-QA