

# 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.		11044	40/50/60 ✓
2	Machined By		V. T. I. n/c Shop	Dy. No. 13.12.609
3	Pallet Die No.		11187 (G.O) n/c	Rev 201
4	Die Category	Drg. No.	M: Jumbo	
5	Out Side Diameter	Drg. No.	680.69 n/c Step: 602 628 n/c	Tapper 2°
6	Inside Diameter	Drg. No.	548.12 n/c	Step length 31
7	Width of Pellet Die	Drg. No.	194.3 n/c	Under cut: 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32.7 x 8.1 n/c / 32.3 x 8.1 n/c (4x8) n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 2 n/c Deep Back Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Hole: 4
12	Tapping PCD		619 n/c	Back Side
13	Tapping Hole Diameter		NIG 2 Check by NIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 33.7 n/c	Tapping Depth: 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Rasi 30/7/13

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

1	Counter Sinking Depth & Finish	ok				Counter 3°
2	External Relief Dia	6.5 n/c / 7.5 n/c	6.5 n/c All Lines	7.5 n/c All Lines		Rev 12
3	External Relief Depth		22 n/c	16 n/c		
4	Inspection Done Before Hardening By (Name)		✓ Rasi			
5	Material Sent For Hardening By (Name)		Lark Ferrace			
6	Material Sent For Hardening On Date		30	12	23	

### Inspected By (Sign) & Date

Rasi 30/7/13

Reviewed by (Engineer-CNC)

Manager-QA