



# 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.		10961	40/50
2	Machined By		V.T.L H/C Shop	Dry No. 18.0.193
3	Pallet Die No.		9980 (8.0) H/C	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/C	Step 00 = 692.9 H/C
6	Inside Diameter	Drg. No.	600.12 H/C	Tapper 12°
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 7.5 H/C	12 x 10 x 7.5 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No of Holes 12 Both Side
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		H2 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.5 H/C	Tapping Depth 18.8 H/C
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

1	Counter Sinking Depth & Finish	OK				Counter = 60°
2	External Relief Dia	8.5 H/C	Outside (23-3)	Inner		Rev. 18
3	External Relief Depth		18 H/C	10 H/C		
4	Inspection Done Before Hardening By (Name)					Ravi
5	Material Sent For Hardening By (Name)					Lark Furnace
6	Material Sent For Hardening On Date		29	12	23	

Inspected By (Sign) & Date

Ravi 29/12/13

Reviewed by (Engineer-CNC)

Manager-QA