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# 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.		10979	36/50
2	Machined By		V.T.L.H/c Step	875
3	Pallet Die No.		10520 (3.0)HH	Reg. No. Lark 3350
4	Die Category	Drg. No.	SS3TD	
5	Out Side Diameter	Drg. No.	620HH Step 00, 612HH	Step length = 19.5HH
6	Inside Diameter	Drg. No.	520.14HH	
7	Width of Pellet Die	Drg. No.	186HH	
8	Grooves as per Drawing	Drg. No.	13x8x5HH / 13x8x5HH	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Step	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		565HH	
13	Tapping Hole Diameter		H20 = Check by H20 R.H	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.3mm Tapping	Depth = 18.8mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Rawi 31/124

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	3.5HH	Outside (3-3)		Inner		Row = 30
3	External Relief Depth		20HH		14HH		
4	Inspection Done Before Hardening By (Name)						Rawi
5	Material Sent For Hardening By (Name)						Lark Porrace
6	Material Sent For Hardening On Date		3	1	24		

**Inspected By (Sign) & Date**

Rawi 31/124

Reviewed by (Engineer-CNC)  
31/124

Manager-QA

Reviewed by (Engineer-CNC)  
31/124

Manager-QA