



# 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.		11122	30/66 ✓
2	Machined By		V.T.L. n/c Shop	30/66 ✓
3	Pallet Die No.		11494 (8.0) n/c	Dry No. 18.02509
4	Die Category	Drg. No.	N-Jumbo	Pass 01
5	Out Side Diameter	Drg. No.	690.69 n/c Step 00: 692.8 Tappers 8°	
6	Inside Diameter	Drg. No.	548.14 n/c	Step length = 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut = 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32x7x8.1 n/c   32x7x8.1 n/c	(4x8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step 3mm
10	Drilling Area Surface Smoothness		ok	Deep Both Side
11	Tapping Operator		n/c Shop	Tapping No
12	Tapping PCD		619 n/c	of H.No = 4
13	Tapping Hole Diameter		M16 3 Check by M16 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 n/c	Tapping Depth = 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 11/124

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

Counter = 30°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	9.0 n/c	Ist Pad	2nd Pad					
3	External Relief Depth		36 n/c	34 n/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		11	1	24				

### Inspected By (Sign) & Date

Ravi 11/124

Reviewed by (Engineer-CNC)

Manager-QA