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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

## Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11263	35/40
2	Machined By		V.T.L. H/c Shop	Drg No. 1.3.0. 865
3	Pallet Die No.		11760 (4.5) H/c	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	390 H/c, Step 002 383 H/c	Step length 11.5
6	Inside Diameter	Drg. No.	310.12 H/c	
7	Width of Pellet Die	Drg. No.	135 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3.1 H/c / 12x8x3 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 = 8 Both Side
12	Tapping PCD		350 H/c	
13	Tapping Hole Diameter		ø3/4" = Check by ø3/4 B.11	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21 H/c Tapping Depth = 19 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

*Ravi* 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 60°
2	External Relief Dia	5.0 H/c	Outside (2-2)		Innen			
3	External Relief Depth		9 H/c		5 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		20	2	24			

Inspected By (Sign) & Date

*Ravi* 30/7/13

*Satish* 30/7/13  
Reviewed by (Engineer-CNC)

Manager-QA