



# 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)

i.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11275	33/43/70
2	Machined By		V.T.L n/c Shop	Dy. H. = 1.8.02 382
3	Pal:et Die No.		10653 (6.0) n/c	Rev 2.00
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	660 n/c, Step 002 623 n/c	Step length 17.8
6	Inside Diameter	Drg. No.	520.12 n/c	Tapper = 12°
7	Width of Pellet Die	Drg. No.	186 n/c	
8	Grooves as per Drawing	Drg. No.	10x10x7 n/c / 10x10x7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No of holes 12 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21 n/c Tapping Depth 18.7 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 23/07/14

1	As per programme no.			2 Slot 25 n/c width 4 n/c Deep Both Side
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 = 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	6.5 n/c / 7.0 n/c	6.5 n/c	All Rows	7.0 n/c	All Rows				
3	External Relief Depth	/	37 n/c		27 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		23	2	24					
<b>Inspected By (Sign) &amp; Date</b>			Ravi 23/07/14							

Reviewed by (Engineer-CNC)

Manager-QA