



# 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)

6991

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11260	6043/55
2	Machined By		N. T.L. M/C Shop	Dy. 18.8.00
3	Pallet Die No.		11638 (B.O) M/C	Rev. 00
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	709 M/C Step 002 699.8 M/C Tappers 12°	
6	Inside Diameter	Drg. No.	600.12 M/C / 600.14 M/C	Step Length 19.8
7	Width of Pellet Die	Drg. No.	222.1 M/C	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 M/C / 12x10x7.5 M/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No of Holes 12 Bolt Size
12	Tapping PCD		640 M/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 81 M/C Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 22/8/14

1	As per programme no.		_____
2	Gun Drilling Work Completed On		_____
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		nt.

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Coard 11.00

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 M/C / 7.0 M/C	6.5 M/C All Rows	7.0 M/C All Rows					
3	External Relief Depth	/	15 M/C	7 M/C					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Korner						
6	Material Sent For Hardening On Date		22	24					

### Inspected By (Sign) & Date

Ravi 22/8/14

Sot... 22/12/14

Reviewed by (Engineer-CNC)

Manager-QA