



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

6993

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.			
2	Machined By		11391	35/40/66
3	Pallet Die No.		V.T.L n/c Shop	Dry Hon 1.8.0-0.09
4	Die Category	Drg. No.	11906 (6.0) n/c	Rev=01
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	680.69 n/c, Step 00 = 698.8 n/c	Tabber = 8°
7	Width of Pellet Die	Drg. No.	548.12 n/c	Step length = 31
8	Grooves as per Drawing	Drg. No.	195 n/c	Under cut = 2.4 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 8 n/c / 32 x 7 x 8 n/c (used) n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No of holes = 4 Both Side
13	Tapping Hole Diameter		619 n/c	
14	Tapping On Second Side	Half pitch of 1st side	NIG = Check by NIG Bolt ok	
15	Tapping Hole Depth		Drill Depth = 33.4 n/c	Tapping Depth = 31.6
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)		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	6.5 n/c / 7.0 n/c	6.5 n/c All Rows	7.0 n/c All Rows					
3	External Relief Depth		31 n/c	98 n/c					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Porrace						
6	Material Sent For Hardening On Date		22	2	24				

Inspected By (Sign) & Date

Ravi 22/8/14

Satish 22/8/14  
Reviewed by (Engineer-CNC)

Manager-QA