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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
Rev. Date	31-07-2013

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11299	36/55
2	Machined By		V.T.L. H/c Shop	Dy. No. 1-2-3 14984
3	Pallet Die No.		11353 (8.0) H/c	Review
4	Die Category	Dr. No.	Extra wide	
5	Out Side Diameter	Dr. No.	630 H/c Step 602 618 H/c	Step length 19.4
6	Inside Diameter	Dr. No.	520.12 H/c	
7	Width of Pellet Die	Dr. No.	222 H/c	
8	Grooves as per Drawing	Dr. No.	13x8x5 H/c / 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping dia of holes - 12 Both Side
12	Tapping PCD		565 H/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 - 21.3 H/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 27/7/14

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

1	Counter Sinking Depth & Finish	ok				Counter 60°
2	External Relief Dia	8.5 H/c	outside (2.3-3)	Inner		low 18
3	External Relief Depth		27 H/c	19 H/c		
4	Inspection Done Before Hardening By (Name)				Ravi	
5	Material Sent For Hardening By (Name)				Lowke Furnace	
6	Material Sent For Hardening On Date		27	2	24	

### Inspected By (Sign) & Date

Ravi 27/7/14

Reviewed by (Engineer-CNC)

Manager-QA