



# 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.		12520	42/50
2	Machined By		V.T.L Mic Shop	Drg No-Lark Std
3	Pallet Die No.		12619 (3.5mm)	6355
4	Die Category	Drg. No.	SSFW	
5	Out Side Diameter	Drg. No.	619.6mm Step on Tapper 12	Step length-15.5mm
6	Inside Diameter	Drg. No.	520.8mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13 X 8 X 5 mm / 13 X 8 X 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	[ Tapping No. of Holes 12 Both Side ]
11	Tapping Operator		Mic Shop	
12	Tapping PCD		565mm	
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-20.4mm Tapping Depth-18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ramanpreet Singh 23/07/14

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-60° Row-35

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.0mm	outside (3-3)	Innel			
3	External Relief Depth		15mm	8mm			
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		23	07	24		

### Inspected By (Sign) & Date

Ramanpreet Singh 23/07/14

*[Signature]*  
23/7/14

Reviewed by (Engineer-CNC)

Manager-QA