



# Lark Engineering Company (India) Pvt. Ltd.

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

7926

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.		1P534	36/45
2	Machined By		V.T.L M/c Shop	Dwg No-LEC 15430
3	Pallet Die No.		1P403(3.0mm)	(Rev00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	610mm	Step length-30mm
6	Inside Diameter	Drg. No.	5P0-12	Under cut-1mm
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13X8X5mm / 13X8X5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 12 Both Side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M 20 Check by M 20 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 01/08/14

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

1	Counter Sinking Depth & Finish	OK						Row-38
2	External Relief Dia	3-3mm	outside 6-3	Inner				
3	External Relief Depth		15mm	9mm				
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		01	08	14			

### Inspected By (Sign) & Date

Ramanpreet Singh 01/08/14

Reviewed by (Engineer-CNC)

Manager-QA