



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.		1P569	30/66
2	Machined By		V.T.L M/c Shop	Drg No - 15P 390
3	Pallet Die No.		12894 (60mm)	(REV 06)
4	Die Category	Drg. No.	M. Jumbo groove-413mm	
5	Out Side Diameter	Drg. No.	68.1mm	Step length - 31mm / 31mm
6	Inside Diameter	Drg. No.	548.12mm	Taper - 8°
7	Width of Pellet Die	Drg. No.	195mm	
8	Grooves as per Drawing	Drg. No.	3PX 7X8mm / 3PX 7X8mm	4X8mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes ?]
10	Drilling Area Surface Smoothness		ok	[Both Side]
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619mm	
13	Tapping Hole Diameter		M 16 check by M 16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 34mm Tapping Depth - 31.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanpreet Singh 09/08/14

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 - 30°

1	Counter Sinking Depth & Finish	ok							Roll - 1P
2	External Relief Dia	7.0mm	All Rows						
3	External Relief Depth		36mm						
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		09	08	24				

Inspected By (Sign) & Date Ramanpreet Singh 09/08/14

R. Reviewed by (Engineer-CNC)

Manager-QA