



# 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.		12669	30/45/65	
2	Machined By		V.T.L M/c Shop	Drg No - LSD 84	
3	Pallet Die No.		12071 (6.0mm)	(Revol)	
4	Die Category	Drg. No.	Jumbo		
5	Out Side Diameter	Drg. No.			
6	Inside Diameter	Drg. No.	830 mm Step 00. 803 mm	Step Length - 43mm	
7	Width of Pellet Die	Drg. No.	700.12 mm	Tapper = 12°	
8	Grooves as per Drawing	Drg. No.	340mm		
9	Fitting Sizes on CNC Plate	Drg. No.	37 X 8 X 12 mm / 37 X 8 X 12 mm		
10	Drilling Area Surface Smoothness		ok	[ Tapping No. of Holes 12 Both Side ]	
11	Tapping Operator		ok		
12	Tapping PCD		M/c Shop		
13	Tapping Hole Diameter		742 mm		
14	Tapping On Second Side	Half pitch of 1st side	M 16 check by M 16 Bolt		
15	Tapping Hole Depth		ok		
16	Perpendicularity of Tapped Hole		Drill Depth - 25.4 mm Tapping Depth - 23.5 mm		
17	Visual Inspection Before Gun Drilling		Yes		
Inspected By (Sign) & Date			Ramanpreet Singh 28/08/14		
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		
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>					
1	Counter Sinking Depth & Finish	ok		Counter - 60° Row - 3P	
2	External Relief Dia	6.5mm, 6.8mm	6.5mm	6.8mm All Rows	
3	External Relief Depth		35mm	20mm	
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		28	08	14
Inspected By (Sign) & Date			Ramanpreet Singh 28/08/14		

Reviewed by (Engineer-CNC)  
 28/8/14

Manager-QA