



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.		12896 ✓	19/66 ✓
2	Machined By		V.T.L M/C Shop	Drg No - LSD 609
3	Pallet Die No.		12941 (6.0mm)	(REV 01) ✓
4	Die Category	Drg. No.	M. Jumbo groove-413mm	
5	Out Side Diameter	Drg. No.	680.1mm ✓	Step od - 693mm
6	Inside Diameter	Drg. No.	548.19mm ✓	Step length - 31mm
7	Width of Pellet Die	Drg. No.	195mm ✓	Taper - 8° ✓
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 mm / 32 x 7 x 8 mm	Under cut - 2.5mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	4 x 8mm ✓
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 4]
11	Tapping Operator		M/C Shop	[Both Side]
12	Tapping PCD		619mm ✓	
13	Tapping Hole Diameter		M16 check by M16 Bolt	Face Side Step 2mm
14	Tapping On Second Side	Half pitch of 1st side	ok	Deel Both Side ✓
15	Tapping Hole Depth		Drill Depth - 34.4mm	Tapping Depth - 31.8mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

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	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 30°

1	Counter Sinking Depth & Finish	ok							Row - 12
2	External Relief Dia	7.5 mm	All Rows						
3	External Relief Depth	—	47mm						
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

[Signature]

Reviewed by (Engineer-CNC)

Manager-QA