



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.		12487	45/50
2	Machined By		V.T.L M/c Shop	Drg No - LEC 12501
3	Pallet Die No.		12545 (5.0mm)	(REV 01)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 mm, Step 00. 893	Step Length - 2mm
6	Inside Diameter	Drg. No.	600.12 mm	Tapping 12
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12.8 x 7 mm 12.8 x 7 mm	
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		640 mm	
13	Tapping Hole Diameter		H20, Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 20.4 mm Tapping Depth - 18.5 mm	
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 - 60°
Row - 27

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	5.5 mm	outside (3-3)	Inner			
3	External Relief Depth		10 mm	5 mm			
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	24		

Inspected By (Sign) & Date Ramanpreet Singh 28/08/14

Sats 28/8/14

Reviewed by (Engineer-CNC)

Manager-QA