



# 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.		12857 ✓	32/42/50
2	Machined By		V.T.L M/c Shop	Drg No - Lark Std
3	Pallet Die No.		12613 (4.0mm)	6355
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620mm	Step length - 19.5mm
6	Inside Diameter	Drg. No.	520.12mm	
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		M20 check by M20 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

Ramanjeet Singh 06/09/14

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 / Hole close (A)	

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

Counter - 600

1	Counter Sinking Depth & Finish	ok						Row - 31
2	External Relief Dia	4.5, 5.0mm	4.5mm	5.0mm	All Rows			
3	External Relief Depth		18mm	8mm				
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		06	09	14			

### Inspected By (Sign) & Date

Ramanjeet Singh 06/09/14

Reviewed by (Engineer-CNC)

Manager-QA