



# 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.		12817	33/43
2	Machined By		V.TL M/c Srol	Drg No - LSD 856
3	Pallet Die No.		13077 (3.0mm)	(REV00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	606mm Step 00, 621.5mm	Step length - 91.5mm
6	Inside Diameter	Drg. No.	52.12mm	Taper = 12°
7	Width of Pellet Die	Drg. No.	PPPmm	Under note 7.75
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of]
10	Drilling Area Surface Smoothness		OK	Holes 12
11	Tapping Operator		M/c Srol	Both Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M 20 Check by M 20 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

Ramanpreet Singh 12/09/14

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

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

Counter-60°

1	Counter Sinking Depth & Finish	OK								Row-38
2	External Relief Dia	3.3mm	All Rows							
3	External Relief Depth		10mm							
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		12	09	14					

### Inspected By (Sign) & Date

Ramanpreet Singh 12/09/14

12/09/14

Reviewed by (Engineer-CNC)

Manager-QA