



# 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

8602

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13377 ✓	35/40 ✓
2	Machined By		V.T.L M/c SROP	DR No - LSD 335
3	Pallet Die No.		12701 (3.5mm)	(REV 00)
4	Die Category	Drg. No.	Senior	✓
5	Out Side Diameter	Drg. No.	500mm	Step length - 17.5mm
6	Inside Diameter	Drg. No.	40.12mm	
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3mm / 12 x 8 x 3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[ Tapping No. of Holes 8 Both Side ]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c SROP	
12	Tapping PCD		754mm ✓	
13	Tapping Hole Diameter		3/4" check by 3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 18.4mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet Singh 23/11/14

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

Counts 60

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.0mm	Outer 8.2mm	Inner 5.2mm			
3	External Relief Depth		8mm	5mm			
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		23	11	24		

Inspected By (Sign) & Date Ramanpreet Singh 23/11/14

Reviewed by (Engineer-CNC) [Signature] 23/11/14

Manager-QA