



# 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.		Roll	36/47
2	Machined By		V.T.C M/C SHOP	Reg No - 258-996
3	Pallet Die No.		12410 (2.8mm)	(REV00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	694 mm / Step OD - 693 mm	Step Length - 21 mm
6	Inside Diameter	Drg. No.	600.12 mm	Taper - 4°
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	14x8x7mm / 14x8x7mm	
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 SHOP	Both Side
12	Tapping PCD		640mm	
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 - 22.8 mm Tapping Depth - 20.7 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ramanpreet Singh 27/5/14

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 - 40

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.1 mm	outside (3-3)	2mm			
3	External Relief Depth		16mm	11mm			
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		27	5	24		

### Inspected By (Sign) & Date

Ramanpreet Singh 27/5/14

Reviewed by (Engineer-CNC)

Manager-QA