



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.		12034	29/45
2	Machined By		V.T.L M/C Shop	Reg No- LS-1062
3	Pallet Die No.		12534 (3.0mm)	(Rev 00)
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	5/0mm, Step od-491mm	Step Length-16.5mm
6	Inside Diameter	Drg. No.	420/12mm	
7	Width of Pellet Die	Drg. No.	173mm	
8	Grooves as per Drawing	Drg. No.	10 X 8.5 X 5mm / 10 X 8.5 X 5mm	
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 Shop	
12	Tapping PCD		455mm	
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-20.5mm Tapping Depth-18.7mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanpreet Singh 30/5/14

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 2 Hole close (A)

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

Counter-60 Row-28

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5mm	outside (2-2)	Inner			
3	External Relief Depth		19mm	16mm			
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		30	5	24		

Inspected By (Sign) & Date Ramanpreet Singh 30/5/14

Sotso 30/5/14

Reviewed by (Engineer-CNC)

Manager-QA