



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.		12013	55/66
2	Machined By		V.T.L M/C Shop	Drg No-LEC 9/36
3	Pallet Die No.		12968 (3.5mm)	(Rev01)
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1032mm	Step length-37mm
6	Inside Diameter	Drg. No.	900.12mm	Taper-3°
7	Width of Pellet Die	Drg. No.	375mm	Undercut-0.5mm
8	Grooves as per Drawing	Drg. No.	29.5 X 8 X 13mm / 29.5 X 8 X 13mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 15
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Both Side
12	Tapping PCD		970mm	
13	Tapping Hole Diameter		M24 check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth-38.3mm Tapping Depth-36.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 05/08/14

2 Slot 32mm

1	As per programme no.			Width 7.5mm
2	Gun Drilling Work Completed On			Deep Both Side
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No / Hole close	

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

Counter-60°

1	Counter Sinking Depth & Finish	ok						Row-59
2	External Relief Dia	4.0mm	outside (4-4)	Inner				
3	External Relief Depth		18mm	17mm				
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		05	08	14			

Inspected By (Sign) & Date

Ramanjeet Singh 05/08/14

Sasouli 5/8/14

Reviewed by (Engineer-CNC)

Manager-QA