

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.		12643	30/63/78
2	Machined By		V.T.L M/c Shop	Drg No - LSD378
3	Pallet Die No.		12992 (60mm)	(Rev 02)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	636mm/632mm	Step Length - 26mm/16.5mm
6	Inside Diameter	Drg. No.	480.12mm/489.1mm/500.1mm	
7	Width of Pellet Die	Drg. No.	182mm	
8	Grooves as per Drawing	Drg. No.	37X12X8X9.5mm/27X12X8X9.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 4
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		540mm	
13	Tapping Hole Diameter		M16 check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	1 Side Tapping 2nd Side Slot	
15	Tapping Hole Depth		Drill Depth - 28.4mm Tapping Depth - 26.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 17/08/24

1 Slot 28mm

1	As per programme no.			Width 17mm
2	Gun Drilling Work Completed On			Deep
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-10
2	External Relief Dia	6.5mm, 7.0mm	6.5mm	7.0mm	ADD Rows		
3	External Relief Depth		43mm	15mm			
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		17	08	24		

Inspected By (Sign) & Date

Ramanpreet Singh 17/08/24

Sanyu 17/08/24

Reviewed by (Engineer-CNC)

Manager-QA