



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8/17

Form No.	CNC/QA/FM/02
Rev. No.	01
Rev. Date	31-07-2013

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12013	60/66
2	Machined By		V.T.L M/C Shop	Drg No - IEC 9136
3	Pallet Die No.		13170 (3.5mm)	(Rev 01)
4	Die Category	Drg. No.	S:Jumbo	
5	Out Side Diameter	Drg. No.	1032 H1 / Step 00, 1033	Step Length - 37mm
6	Inside Diameter	Drg. No.	900.12 H1	Taper = 3°
7	Width of Pellet Die	Drg. No.	375mm	Under cut = 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	
10	Drilling Area Surface Smoothness		OK	[ Tapping No. of Holes 15 Both Side ]
11	Tapping Operator		M/C Shop	
12	Tapping PCD		970mm	
13	Tapping Hole Diameter		M 24 Check by M 24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 38.4mm Tapping Depth - 36.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ramanpreet Singh 31/08/14

1	As per programme no.			[ 2 Slot 32.1mm width 7.5mm Deep Both Side ]
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 - 59

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	4.0mm	outside (4-4)	Inner				
3	External Relief Depth		13mm	6mm				
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		31	08	24			

### Inspected By (Sign) & Date

Ramanpreet Singh 31/08/14

Sets  
31/8/14

Reviewed by (Engineer-CNC)

Manager-QA