



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.		12640	60/66
2	Machined By		V.T.C M/c Shop	Dr No- LSD 9136
3	Pallet Die No.		13357 (3.5mm)	(Rev01)
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1032mm	Step od-1033mm
6	Inside Diameter	Drg. No.	900.12mm	Step length-37mm
7	Width of Pellet Die	Drg. No.	375mm	Taper-3°
8	Grooves as per Drawing	Drg. No.	29.5 X 8 X 13mm / 29.5 X 8 X 13mm	Under cut-0.5mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 15 Both Side]
10	Drilling Area Surface Smoothness		ok	
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 09/09/24

1	As per programme no.			[2 Slot 32 mm 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°

1	Counter Sinking Depth & Finish	ok								Row-59
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		09	09	24					

Inspected By (Sign) & Date

Ramanpreet Singh 09/09/24

Reviewed by (Engineer-CNC)

Manager-QA