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
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12636	60/66
2	Machined By		V.T.L N/C Shop	Drg No: LEC 9136
3	Pallet Die No.		13429 (3.5) MM	Rev: 01
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1032 MM Step OD = 1033 MM	Tapper = 3°
6	Inside Diameter	Drg. No.	900.12 MM / 900.2 MM (A)	Step length = 37 MM
7	Width of Pellet Die	Drg. No.	375 MM	37.3
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 MM / 29.5 x 8 x 13 MM	Undercut = 0.5 MM
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No of Holes 15 Both Side
12	Tapping PCD		970 MM	
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 = 38.6 MM	Tapping Depth = 36.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 7/10/24	2 Slot 32.1 MM width 7.5 MM Deep Both Side
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	

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	4.0 MM	Out Side (4-4)		Inner			
3	External Relief Depth		13 MM		6 MM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		7	10	24			
	Inspected By (Sign) & Date		Ravi 7/10/24					

Satya 7/10/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner