

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.		13187	35/63/78
2	Machined By		V. T. L. M/c Shop	Drg No. L-30-390
3	Pallet Die No.		13616 (6.5) mm	Rev 2.01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	636 mm / 632 mm / Step 002	630.5 mm / 543 mm
6	Inside Diameter	Drg. No.	480.12 mm / 489.12 / 500.12 mm	Step length = 26 mm
7	Width of Pellet Die	Drg. No.	182 mm	16.5
8	Grooves as per Drawing	Drg. No.	37 x 12 x 8 x 9.5 mm / 27 x 12 x 8 x 9.5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		540 mm	Tapping No. of holes = 4
13	Tapping Hole Diameter		M16: Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and Third Side One Slot	
15	Tapping Hole Depth		Drill Depth: 28.4 mm	Tapping Depth: 26.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/11/24

1	As per programme no.			1 Slot 28.1 mm width 17 mm Depth
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

1	Counter Sinking Depth & Finish	ok					Counter = 30° Row = 9
2	External Relief Dia	7.0 mm / 7.5 mm	7.0 mm All Rows	243 mm			
3	External Relief Depth		7.5 mm All Rows	215 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		6	11	24		
Inspected By (Sign) & Date			Ravi 6/11/24				

Sohi 6/11/24

Reviewed by (Engineer-CNC)

Manager-QA