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.		10005	27/50
2	Machined By		V.T.L M/C Shop	Drg No. 1.S.D.683
3	Pallet Die No.		10111 (4.5) MM	Rev 200
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	520MM Step [redacted] OD = 491MM	
6	Inside Diameter	Drg. No.	420.12 MM	Step length = 17.5
7	Width of Pellet Die	Drg. No.	182 MM	
8	Grooves as per Drawing	Drg. No.	10x8x3MM | 10x8x3MM	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No. of Holes, 8 Both side
12	Tapping PCD		454 MM	
13	Tapping Hole Diameter		Φ3/4" Check by Φ3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 18.5 MM Tapping Depth. 16.8 MM	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 4/8/23	
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

1	Counter Sinking Depth & Finish	ok						Ravi 23
2	External Relief Dia	5.0MM	outside (2-2)		Inner			
3	External Relief Depth		27MM		23MM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		4	8	23			
	Inspected By (Sign) & Date		Ravi 4/8/23					

4/8/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner