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.		9966	34/50
2	Machined By		V.T.L. M/c. Shop	Drg No: L-S-C-9980
3	Pallet Die No.		10003 (2.8) MM	Rev: 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 MM, Step OD: Tapper: 12° Step length: 18 MM	
6	Inside Diameter	Drg. No.	520.12 MM	
7	Width of Pellet Die	Drg. No.	222 MM	
8	Grooves as per Drawing	Drg. No.	13×8×5 MM / 13×8×5 MM	
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: 12 Both Side
12	Tapping PCD		565 MM	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.4 MM Tapping Depth: 18.8 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 40
2	External Relief Dia	3.1 MM	Outside (3-3)		Inner				
3	External Relief Depth		22 MM		16 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		4	8	23				
	Inspected By (Sign) & Date		Ravi 4/8/23						

Reviewed by (Engineer-CNC) 4/8/23

Manager-QA

Scanned with CamScanner