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.		10022	45/50
2	Machined By		V.T.L M/c Shop	Drg No: L-S.O. 442
3	Pallet Die No.		10883 (8.0) MM	Rev: 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 MM Step OD: 492 MM	Step length: 13.5
6	Inside Diameter	Drg. No.	420.12 MM	
7	Width of Pellet Die	Drg. No.	159.2 MM (B)	
8	Grooves as per Drawing	Drg. No.	7x7x5 MM / 7x7x5 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, 8 Both Side
12	Tapping PCD		455 MM	
13	Tapping Hole Diameter		03/4" 2 Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 22.4 MM Tapping Depth: 20.7	
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						Row-12
2	External Relief Dia	8.3 MM	Outside (2-2)		Inner			
3	External Relief Depth		13 MM		5 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					

4/8/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner