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.		9988	48/50
2	Machined By		V.T.L. M/c Shop	Drg No. L.E.C. 9980 Rev. 00
3	Pallet Die No.		10561 (4.0) MM	
4	Die Category	Drg. No.	Endwide	
5	Out Side Diameter	Drg. No.	62mm Step OD = Tapper, 12° Step length, 18M	
6	Inside Diameter	Drg. No.	50.12 MM	
7	Width of Pellet Die	Drg. No.	22.2 MM	
8	Grooves as per Drawing	Drg. No.	13x8x5 MM / 13x8x5	
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		56.5 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 20.4M = Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ravi 8/8/23	
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 2 3 1
2	External Relief Dia	4.3 MM	Outside (3-3)		Inner				
3	External Relief Depth		12 MM		8 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		8	8	23				
	Inspected By (Sign) & Date		Ravi 8/8/23						

8/8/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner