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.		9980	39/45
2	Machined By		V.T.L. M/C Shop	Dg No. 1.8.9.483
3	Pallet Die No.		10768 (6.0) MM	Rev. 03
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 MM Step OD. 387 MM	Step length. 10.4
6	Inside Diameter	Drg. No.	310.12 MM	
7	Width of Pellet Die	Drg. No.	134 MM	
8	Grooves as per Drawing	Drg. No.	8x7x3 MM / 8x7x3 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		350 MM	
13	Tapping Hole Diameter		1/2" = Check by 1/2" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth. 16.4 MM Tapping Depth = 14.7 MM	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 11/8/23	
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							Rev. 13
2	External Relief Dia	6.5 MM	[redacted]	6.5 MM All Lines					
3	External Relief Depth			6 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		11	8	23				
	Inspected By (Sign) & Date		Ravi 11/8/23						

Reviewed by (Engineer-CNC) 11/8/23

Manager-QA

Scanned with CamScanner