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.		12900	21/40
2	Machined By		V.T.L M/c. Shop	Drg No: L.S.D.21 Rev. 01
3	Pallet Die No.		12457 (2.8) HH	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 HH, Step OD: 499 HH	Tapper: 12° Step length: 17 HH
6	Inside Diameter	Drg. No.	42.12 HH	
7	Width of Pellet Die	Drg. No.	158 HH	
8	Grooves as per Drawing	Drg. No.	12x8x3 HH / 12x8x3 HH	
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 HH	
13	Tapping Hole Diameter		~~Ø~~ Ø3/4" x Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.4 HH — Tapping Depth: 16.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 1/10/24	
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							Counter: 60° Row: 26
2	External Relief Dia	3.3 HH	OD Side (2-25)		Inner				
3	External Relief Depth		22 HH		19 HH				
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		1	10	24				
	Inspected By (Sign) & Date		Ravi 1/10/24						

1/10/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner