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.		12905	415/65
2	Machined By		V.T.L. N/C Shop	Dwg No. 1.3.9.1151
3	Pallet Die No.		12988 (8.0) HH	Rev. 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	790 HH, Step OD - 798 HH	Tapper 4°
6	Inside Diameter	Drg. No.	BG 0.12 HH	Step length 25.5
7	Width of Pellet Die	Drg. No.	3.84 HH	Under cut = 4 HH
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 HH / 21.5 x 8 x 10 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		N/C Shop	Tapping No of Holes = 12 Both Side
12	Tapping PCD		725 HH	
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 = 30.4 HH	Tapping Depth =
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 30/9/24	
1	As per programme no.		—	2 Slot 381 HH Inside 8 HH Deep Both Side
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

Counter = 60°

1	Counter Sinking Depth & Finish	Ok							Row = 11
2	External Relief Dia	8.5 HH	Outside (3-3)		Inner				
3	External Relief Depth		28 HH		20 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		30	9	24				
	Inspected By (Sign) & Date		Ravi 30/9/24						

Satya 30/9/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner