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.		12576	67/67
2	Machined By		V.T.L N/C Shop	Dg No. 1117 Rev 2 05
3	Pallet Die No.		12996(16.0)HH	
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680 HH Step OD = 693.5HH	Tapper 5°
6	Inside Diameter	Drg. No.	548.1 HH	Step length = 38 HH
7	Width of Pellet Die	Drg. No.	177.9 HH	Under cut = 4.4HH
8	Grooves as per Drawing	Drg. No.	30x7x8 HH / 30x7x8 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 2 Both Side
12	Tapping PCD		614 HH	
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 35.4HH	Tapping Depth 30 HH
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 9/10/24	
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							Ravi 5
2	External Relief Dia	—	—	No	—	Relief			
3	External Relief Depth		—						
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		9	10	24				
	Inspected By (Sign) & Date		Ravi 9/10/24						

Sanjay 9/10/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner