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.		13001 ✓	42/55 ✓
2	Machined By		V.T.L. N/C Shop	Dy No. I.S.D = 955
3	Pallet Die No.		18679 (4.0) HH ✓	Row 00 ✓
4	Die Category	Drg. No.	55970	
5	Out Side Diameter	Drg. No.	830 HH ✓ Step OD = 812 HH ✓ Step length 10 HH	
6	Inside Diameter	Drg. No.	520.12 HH ✓	
7	Width of Pellet Die	Drg. No.	186 HH ✓	
8	Grooves as per Drawing	Drg. No.	13×8×3 HH | 13×8×3 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		565 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 = 20.4 HH Tapping Depth = 18.6 ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Rao 10/10/24	
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. 1 Hole Colosed (A)	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter Go ✓ Row → 25

1	Counter Sinking Depth & Finish	Ok						
2	External Relief Dia	4.5 HH ✓	Outside (3-3)		Inner			
3	External Relief Depth		17 HH ✓		13 HH ✓			
4	Inspection Done Before Hardening By (Name)		Rao ✓					
5	Material Sent For Hardening By (Name)		Lark Foxmack					
6	Material Sent For Hardening On Date		10	10	24			
	Inspected By (Sign) & Date		Rao 10/10/24					

Satya 10/10/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner