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.		13179	27/47
2	Machined By		V.T.L M/c Shop	Drg No. LEC-21897
3	Pallet Die No.		1337-6(3.0) MM	Rev. 00
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	614 MM, Step OD, 621.4 MM	Step length 21.5
6	Inside Diameter	Drg. No.	520.12 MM	Tapper 12
7	Width of Pellet Die	Drg. No.	222 MM	Under cut 3.7 MM
8	Grooves as per Drawing	Drg. No.	13x8x5 MM / 13x8x5 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 12 Both Side
12	Tapping PCD		565 MM	
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 MM	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 5/11/24	
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 Colused	

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

1	Counter Sinking Depth & Finish	ok						Counter 60° Row 37
2	External Relief Dia	3.5 MM	Outside (3-3)		Inner			
3	External Relief Depth		23 MM		20 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		5	11	24			
	Inspected By (Sign) & Date		Ravi 5/11/24					

5/11/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner