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.		10071	45/45
2	Machined By		V.T.L. N/C Shop	Drg No. L.S.9-366
3	Pallet Die No.		10279 (2.0) HH	Rev-00
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	690 HH Step OD- 688 HH	596 HH
6	Inside Diameter	Drg. No.	530.1 HH	Step length- 28 HH
7	Width of Pellet Die	Drg. No.	258 HH	17.5 HH
8	Grooves as per Drawing	Drg. No.	27×8×8 HH / 43×8×8 HH	Undercut- 31 HH
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Tapping No of Holes- 8
11	Tapping Operator		N/C Shop	
12	Tapping PCD		594 HH	
13	Tapping Hole Diameter		M16- Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping And IInd Side One Slot	
15	Tapping Hole Depth		Drill Depth- 25.4 HH, Tapping Depth- 23.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Rao 21/8/23	1 SLOT 28 HH width 8 HH Deep
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 Closed (A)	maintained after Hard.

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

1	Counter Sinking Depth & Finish	ok						Rao 21/8/23
2	External Relief Dia	2.5 HH	Outside (3-3)		Inner			
3	External Relief Depth		4 HH		Nill			
4	Inspection Done Before Hardening By (Name)		Rao					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		21	8	23			
	Inspected By (Sign) & Date		Rao 21/8/23					

Satya 21/8/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner