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.		9965 ✓	55/60 ✓
2	Machined By		V.T.L N/C. Shop	Dgn No. 1.8.0.408 ✓ Rev 00
3	Pallet Die No.		10643 (10:0) MM	
4	Die Category	Drg. No.	M. Jumbo ✓	
5	Out Side Diameter	Drg. No.	720 MM ✓ Step OD = 693 MM	Tapper 12° ✓
6	Inside Diameter	Drg. No.	600.12 MM ✓	Step length 20 MM
7	Width of Pellet Die	Drg. No.	222 MM ✓	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 MM / 12 x 8 x 7 MM ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		N/C. Shop	Tapping No of Hole = 12 Both Side ✓
12	Tapping PCD		640 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 = 18.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 21/8/23	
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 13
2	External Relief Dia	10.5 MM ✓	Outside (3-3)		Inner			
3	External Relief Depth		15 MM ✓		5 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		21	8	23			
	Inspected By (Sign) & Date		Ravi 21/8/23					

Reviewed by (Engineer-CNC) 21/8/23

Manager-QA

Scanned with CamScanner