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 M/c Shop	Drg No. I.S.D. 408
3	Pallet Die No.		10642 (10.0) MM	Rev 00
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.	12×8×7 MM | 12×8×7 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		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 22/8/23	
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						Row: 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		22	8	23			
	Inspected By (Sign) & Date		Ravi 22/8/23					

22/8/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner