



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

5627

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.		9280	45/60
2	Machined By		V.T.L H/C Shop	Drg No = L.S.O. = 584
3	Pallet Die No.		10475 (8.0) H	Rev = 01
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H	Tapper = 4°
6	Inside Diameter	Drg. No.	660.12 H	Step length = 25.4
7	Width of Pellet Die	Drg. No.	324 H	Under cut = 29 H
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 H	
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 10 H	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		725 H	Tapping No. of Holes = 12
13	Tapping Hole Diameter		H202 Check by H20 Bolt	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 30.4 H	Tapping Depth = 28.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date				
1	As per programme no.			2 slot 32.1 H width 8 H Deep Both Side
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		Len = 28
2	External Relief Dia	8.5 H	outside (3-3)	
3	External Relief Depth		23 H	Inner 15 H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Keshav	
6	Material Sent For Hardening On Date		9 6 23	
Inspected By (Sign) & Date				
			Ravi	9/6/23

Reviewed by (Engineer-CNC)

Manager-QA