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.		13461	36/50
2	Machined By		V.T.L M/c Shop	Drg No. Lark 6355 3510
3	Pallet Die No.		9019 (3.0) mm	
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	620 mm, Step OD = 612 mm	Step length = 19.4
6	Inside Diameter	Drg. No.	520.12 mm	
7	Width of Pellet Die	Drg. No.	222 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 = 21 mm Tapping Depth = 18.8 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 27/11/24	
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	

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

Counter = 60°

1	Counter Sinking Depth & Finish	ok						Row = 38
2	External Relief Dia	3.5 mm	Outside (3-3)		Inner			
3	External Relief Depth		20 mm		14 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		27	11	24			
	Inspected By (Sign) & Date		Ravi. 27/11/24					

Satya 29/11/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner