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.		13468	40/40
2	Machined By		V.T.L. M/c Shop	Drg No. = 63.D.984
3	Pallet Die No.		13855 (5.0) mm	Rev 200
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	395 mm, Step OD. 389 mm	Step length 9.5
6	Inside Diameter	Drg. No.	315.12 mm	
7	Width of Pellet Die	Drg. No.	145 mm	
8	Grooves as per Drawing	Drg. No.	16x6x4 mm / 16x6x4 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, 8 Both Side
12	Tapping PCD		356 mm	
13	Tapping Hole Diameter		Ø3/4" - Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 mm Tapping Depth 18.6 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 12/12/24	
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						Raw = 14
2	External Relief Dia	5.5 mm	Outside (2-2)		Inner			
3	External Relief Depth		5 mm		Mill			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		12	12	24			
	Inspected By (Sign) & Date		Ravi 12/12/24					

Satyam 13/12/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner