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.		13238	60/65.5
2	Machined By		V.T.L M/c. Shop	Dy No. 13.D.2903
3	Pallet Die No.		14071 (12.0) HH	Rev. 03
4	Die Category	Drg. No.	33STD	
5	Out Side Diameter	Drg. No.	639.6 HH, Step OD 658.3 HH, Tapper 8°	
6	Inside Diameter	Drg. No.	508.8 HH (ID Step 538.7 / 523.3)	Step length 32 HH
7	Width of Pellet Die	Drg. No.	175 HH	
8	Grooves as per Drawing	Drg. No.	30x21x7.85 HH / 9.4x24.6 HH	Face Side Step 0.5 HH Deep
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. 4
12	Tapping PCD		574 HH	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one Side Tapping and IInd Side 4 Slot	
15	Tapping Hole Depth		Drill Depth. 30.3 HH Tapping Depth. 28.6 HH	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 18/12/24	
1	As per programme no.		—	4 Slot
2	Gun Drilling Work Completed On		—	51.5 HH Long
3	Hole Finish In Gun Drilling	Marked	ok	28.1 HH width
4	Defective Holes (If Any)		No	15 HH Deep

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

1	Counter Sinking Depth & Finish	ok							Counter 60° Rows 5
2	External Relief Dia	12.5 HH	All Rows						
3	External Relief Depth		5.5 HH						
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		18	12	24				
	Inspected By (Sign) & Date		Ravi 18/12/24						

Reviewed by (Engineer-CNC) 18/12/24

Manager-QA

Scanned with CamScanner