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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.		13671	50/66
2	Machined By		V.T.L. H/C. Shop	Dy No. 12.5.300
3	Pallet Die No.		13633 (8.0) HH	Rev. 08
4	Die Category	Drg. No.	H. Jumbo Groove 4+3	
5	Out Side Diameter	Drg. No.	680.1 HH Step OD = 693.1 HH	Tapper 8°
6	Inside Diameter	Drg. No.	546.12 HH (Bor = 548.12 HH)	Step length 31 HH
7	Width of Pellet Die	Drg. No.	195 HH	Under cut = 31.8 HH
8	Grooves as per Drawing	Drg. No.	32x7x9.1 HH / 32x7x9.1 HH	(4x8) HH
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	Face Side Step 2 HH Rach Both Side
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		619 HH	Tapping No of Holes 2 Both Side
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth = 33.2 HH	Tapping Depth 31.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 25/12/24	
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

1	Counter Sinking Depth & Finish	Ok							Counter 30° Rad 10
2	External Relief Dia	9.0 HH	All Holes						
3	External Relief Depth		16	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		25	12	24				
	Inspected By (Sign) & Date		Ravi 25/12/24						

Satya 25/12/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner