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.		9700	50/50
2	Machined By		V.T.L. M/c Shop	Dwg No: Lark 8355 8370
3	Pallet Die No.		9940 (6.0) MM	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 MM Step 00 = 611.9 MM	Step length = 19.4
6	Inside Diameter	Drg. No.	520.12 MM	
7	Width of Pellet Die	Drg. No.	228 MM	
8	Grooves as per Drawing	Drg. No.	12.7 x 8 x 5 MM / 12.7 x 8 x 5 MM	Inner Pad = 180.6
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		585 MM	
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth = 22.4 MM Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 17/6/23	
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							Rev = 23
2	External Relief Dia	6.3 MM	Outside (3-3)		Inner				
3	External Relief Depth		5 MM		Nill				
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		17	6	23				
	Inspected By (Sign) & Date		Ravi 17/6/23						

17/6/23

Reviewed by (Engineer-CNC)

Manager-QA