90/8

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.		13815	36/40
2	Machined By		V.T.L M/c Shop	Dy No. 12.C.15.62 Rev. 00
3	Pallet Die No.		13228 (4.0) HH	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 HH, Step OD = 493.88	Tapper = 12°
6	Inside Diameter	Drg. No.	420.12 HH	Step length = 13 HH
7	Width of Pellet Die	Drg. No.	158 HH	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 HH / 12 x 8 x 3 HH	
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		454 HH	
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 = 18.3 HH	Tapping Depth = 16.5 HH
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 17/1/25	
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 = 60° Rev. do
2	External Relief Dia	4.5 HH	Outside (2.2)		Inner			
3	External Relief Depth		8 HH		4 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		17	1	25			
	Inspected By (Sign) & Date		Ravi 17/1/25					

Satya 17/1/25.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner