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.		9735	38/50
2	Machined By		V.T.L w/c Shop	Drg No: LEC0998
3	Pallet Die No.		10016 (3.0) HH	Rev-00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	820 HH Step OD: Tapper: 12° Step length: 18	
6	Inside Diameter	Drg. No.	520.12 HH	
7	Width of Pellet Die	Drg. No.	222 HH	
8	Grooves as per Drawing	Drg. No.	13×8×5 HH / 13×8×5 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: 12 Both Side
12	Tapping PCD		565 HH	
13	Tapping Hole Diameter		M20 × Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth: 20.4 HH	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						Ravi 38
2	External Relief Dia	3.5 HH	Outside 3-3		Inner			
3	External Relief Depth		18 HH		18 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	6	23			
	Inspected By (Sign) & Date		Ravi 17/6/23					

17/6/23

Reviewed by (Engineer-CNC)

Manager-QA