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.		10149	33/50
2	Machined By		V.T.L M/c Shop	Dg No 1-89.45
3	Pallet Die No.		10569, (3.0) MM	Rev - 00
4	Die Category	Drg. No.	JEN	
5	Out Side Diameter	Drg. No.	730MM, Step OD: 743.4MM	Tapper: 10°
6	Inside Diameter	Drg. No.	630.12MM	Step length: 23MM
7	Width of Pellet Die	Drg. No.	290MM	Under cut: 6.75
8	Grooves as per Drawing	Drg. No.	15×8×5 MM / 15×8×5 MM	
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: 16 Both Side
12	Tapping PCD		685 MM	
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: 20.4MM	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 8/9/23	
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						Row: 52
2	External Relief Dia	0.3MM	Outside (3-3)		Inner			
3	External Relief Depth		23MM		17MM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		8	9	23			
	Inspected By (Sign) & Date		Ravi 8/9/23					

8/9/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner