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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.		9772	36 / 46 / 55
2	Machined By		V.T.L. N/C Shop	Drg No. 1.E.C.14924 Rev. 00
3	Pallet Die No.		9406 (4.0) MM	
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	629.7 MM (A) Step OD = 611.7 MM Step long 19.4 (A)	
6	Inside Diameter	Drg. No.	520.12 MM	
7	Width of Pellet Die	Drg. No.	22.2 MM	
8	Grooves as per Drawing	Drg. No.	13 x 9 x 5 MM / 13 x 8 x 5 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		N/C Shop	Tapping No of Holes 12 Body Side
12	Tapping PCD		565 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. 20.4 MM ← Tapping Depth. 18.2	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Rai 20/6/23	
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. 31
2	External Relief Dia	4.5MM / 5.0MM	4.5 MM	All Lines	5.0 MM	All Lines		
3	External Relief Depth		19 MM		9 MM			
4	Inspection Done Before Hardening By (Name)		Rai					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		20	6	23			
	Inspected By (Sign) & Date		Rai 20/6/23					

21/6/23

Reviewed by (Engineer-CNC)

Manager-QA