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.		10460/	26/46/60/
2	Machined By		V.T.L. M/c. Shop	Dy No: L.S.O. 727
3	Pallet Die No.		10997 (4.0) HH/	Rev: 00/
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 HH/ Step OD: 792 HH	Step length 28.5
6	Inside Diameter	Drg. No.	660.12 HH	Under cut: 6 HH
7	Width of Pellet Die	Drg. No.	3.24 HH/	
8	Grooves as per Drawing	Drg. No.	21.5x8x8 HH / 21.5x8x8 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		795 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. 31.4 HH/ Tapping Depth 29.7	
16	Perpendicularity of Tapped Hole		Yes	(A)
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 17/10/23	
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: 47
2	External Relief Dia	4.5HH / 5.0HH	4.5HH All Lines		5.0HH All Lines			
3	External Relief Depth	/ /	24 HH/		14 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	10	23			
	Inspected By (Sign) & Date		Ravi 17/10/22					

Sahu 17/10/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner