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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.		10548	36/5 8752
2	Machined By		V.T.L. M/C Shop	Drg No. Lark SSTD
3	Pallet Die No.		9176 (9.8) MM	
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	620 MM / Step OD: 612 MM	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 MM	
7	Width of Pellet Die	Drg. No.	18.6 MM	
8	Grooves as per Drawing	Drg. No.	13×8×5 MM / 13×8×5 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 Hole = 12 Both Side
12	Tapping PCD		565 MM	
13	Tapping Hole Diameter		M20 × Check by M20 Roll	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 MM Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Raj 16/10/23	
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							Rej = 31
2	External Relief Dia	3.1 MM	Outside (3-3)			Inner			
3	External Relief Depth		19 MM			14 MM			
4	Inspection Done Before Hardening By (Name)				Raj				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		16	10	23				
	Inspected By (Sign) & Date				Raj 16/10/23				

Reviewed by (Engineer-CNC) Sanjiv 16/10/23

Manager-QA

Scanned with CamScanner