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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.			40/40
2	Machined By		16127 ✓	
3	Pallet Die No.		U7L m/c Shop	Drg No. LSD 400
4	Die Category	Drg. No.	15666 (4.0) mm ✓	(Revo)
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 mm Step to 490.2 mm ✓	
7	Width of Pellet Die	Drg. No.	490 mm	Step length 14 mm
8	Grooves as per Drawing	Drg. No.	159 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	7x7x5 mm	Tapping No of hole 8
10	Drilling Area Surface Smoothness		OK	Both side
11	Tapping Operator		m/c Shop	
12	Tapping PCD		455 ✓	
13	Tapping Hole Diameter		Ø 7/4" check by Ø 3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 22.5 mm Tapping Depth 20.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			makeh 8/10/28	
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		Counter 60°
2	External Relief Dia	4.5 mm	60° (2-2)	2mm
3	External Relief Depth		4mm	0
4	Inspection Done Before Hardening By (Name)		makeh	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		8 10 28	
Inspected By (Sign) & Date			makeh	

Subhan
8/10/28

Reviewed by (Engineer-CNC)

Manager-QA