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.		9947	Go/Go
2	Machined By		V.T.L H/C Shop	Dg No. L.S.D. 534
3	Pallet Die No.		11038 (10.0) HT	Rev. 01
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 HH, Step OD, 797.8 HH	Tapper. 4°
6	Inside Diameter	Drg. No.	660.12 HH	Step length 95.5
7	Width of Pellet Die	Drg. No.	324 HH	Under Cut, 3.9 HH
8	Grooves as per Drawing	Drg. No.	21.5x8x10 HH / 21.5x8x10 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of Holes 12 Both Side
12	Tapping PCD		725 HH	
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 30.4 HH Tapping Depth = 23.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 21/10/23	
1	As per programme no.		—	2 SLOT 32.1 HH wide 8 HH Deep Both Side
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 19
2	External Relief Dia	—	—	Not	Relief	—		
3	External Relief Depth		—	—		—		
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		to Keshav					
6	Material Sent For Hardening On Date		21	10	23			
	Inspected By (Sign) & Date		Ravi 21/10/23					

Reviewed by (Engineer-CNC) 21/10/23

Manager-QA

Scanned with CamScanner