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.		10631	33/40 9/19
2	Machined By		V.T.L N/C Shop	Dy No. Lark 3810
3	Pallet Die No.		7413 (3.0) HH	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 HH / Step OD = 395 HH	Step length 14.5
6	Inside Diameter	Drg. No.	32.12 HH	
7	Width of Pellet Die	Drg. No.	14.8 HH	
8	Grooves as per Drawing	Drg. No.	15.5x7x2 HH / 15.5x7x2 HH	
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 = 8 Both side
12	Tapping PCD		355 HH	
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth = 20.8 HH Tapping Depth = 19 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 31/10/23	
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						Row 2 Do
2	External Relief Dia	3.5 HH	Outside (2 — 2)		Inner			
3	External Relief Depth		13 HH		7 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		31	10	23			
	Inspected By (Sign) & Date		Ravi 31/10/23					

Sd/- 31/10/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner