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.		10420	40/40 ✓ 8195
2	Machined By		V.T.L. M/C Shop	Dy No. Lark 35570
3	Pallet Die No.		10700 (5.0) HH	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 HH ✓ Step OD: 491 HH ✓	Step length: 17.5 HH
6	Inside Diameter	Drg. No.	420.14 HH ✓	
7	Width of Pellet Die	Drg. No.	158 HH ✓	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 HH / 12 x 8 x 3 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: 8 Both Side
12	Tapping PCD		454 HH / 453.9 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: 19.8 HH ✓ Tapping Depth: 17.6 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							Rev: 17
2	External Relief Dia	5.3 HH ✓	Outside (2-2)		Inner				
3	External Relief Depth		5 HH		Nill				
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						

Sats ✓ 31/10/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner