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.		9816	33/40
2	Machined By		V.T.L M/c Shop	Dg No. 18.0.21
3	Pallet Die No.		9807 (3.0) MM	Rev.01
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 MM Step OD = 499 MM Tapper = 12°	Step length = 17 MM
6	Inside Diameter	Drg. No.	420.12 MM	
7	Width of Pellet Die	Drg. No.	158 MM	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 MM / 18 x 8 x 3 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 holes, 8 Both side
12	Tapping PCD		454 MM	
13	Tapping Hole Diameter		ϕ3/4" = Check by ϕ3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth = 18.4 MM Tapping Depth = 16.8 MM	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 28/6/23	
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 = 25
2	External Relief Dia	3.5 MM	Out Side (2 - 2)		Inner			
3	External Relief Depth		13 MM		7 MM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		28	6	23			
	Inspected By (Sign) & Date		Ravi 28/6/23					

28/6/23

Reviewed by (Engineer-CNC)

Manager-QA