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.		10515	24/40 9109 SS10
2	Machined By		V.T.L. N/C Shop	Dy No. = Lark
3	Pallet Die No.		11133 (3.5) 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.	320.12 HH	
7	Width of Pellet Die	Drg. No.	142 HH	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 HH | 15.5 x 7 x 2 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 = 21 HH Tapping Depth = 19 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Rao 4/11/23	
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 — 1 Hole Colosed (A)	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Rao 18
2	External Relief Dia	3.8 HH	Outside (2-2)		Inner			
3	External Relief Depth		20 HH		16 HH			
4	Inspection Done Before Hardening By (Name)		Rao					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		4	11	23			
	Inspected By (Sign) & Date		Rao 4/11/23					

Reviewed by (Engineer-CNC) 4/11/23

Manager-QA

Scanned with CamScanner