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.		10642	33/50
2	Machined By		V.T.L M/c Shop	Dy No. 13.0.1950
3	Pallet Die No.		10780 (3.0) HH	Rev = 00
4	Die Category	Drg. No.	7&10	
5	Out Side Diameter	Drg. No.	730HH, Stck OD. 743.5HH	Tapper = 10°
6	Inside Diameter	Drg. No.	630.12 HH	Stck length 23HH
7	Width of Pellet Die	Drg. No.	290 HH	Under cut = 8.75HH
8	Grooves as per Drawing	Drg. No.	15x8x5 HH / 15x8x5 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 = 16
12	Tapping PCD		685HH	Both Side
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.4HH Tapping Depth. 18.8HH	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 6/11/23	
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	

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

1	Counter Sinking Depth & Finish	ok						Rev2 52
2	External Relief Dia	3.3HH	Out Side (3-3)		Inner			
3	External Relief Depth		23HH		17HH			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		6	11	23			
	Inspected By (Sign) & Date		Ravi 6/11/23					

6/11/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner