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.		10618	410/55
2	Machined By		V.T.L. N/C Shop	Dwg No. L.E.C/14924
3	Pallet Die No.		11150 (8.0) HH	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	630 HH Step OD = 618 HH	Step length = 19.5 HH
6	Inside Diameter	Drg. No.	520.12 HH	
7	Width of Pellet Die	Drg. No.	222 HH	
8	Grooves as per Drawing	Drg. No.	13x8x5 HH / 13x8x5 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 = 12 Both Side
12	Tapping PCD		565 HH	
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 = 20.4 HH Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 7/11/23	
1	As per programme no.		———	
2	Gun Drilling Work Completed On		———	
3	Hole Finish In Gun Drilling	Marked	Ok	
4	Defective Holes (If Any)		Nil	

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

1	Counter Sinking Depth & Finish	Ok						Ravi 18
2	External Relief Dia	3.5 HH	Outside 33-31		Inner			
3	External Relief Depth		23 HH		15 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		7	11	23			
	Inspected By (Sign) & Date		Ravi 7/11/23					

Reviewed by (Engineer-CNC) 7/11/23

Manager-QA

Scanned with CamScanner