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.		10608	L10/45
2	Machined By		V.T.L. N/C Shop	Drg. No. L.S.D. 916 Rev. 00
3	Pallet Die No.		10485 (6.0) HN	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	510 HN, Step OD = 493 HN	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 HN	
7	Width of Pellet Die	Drg. No.	160 HN	
8	Grooves as per Drawing	Drg. No.	11 x 5 x 3 HN / 11 x 5 x 3 HN	
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		454 HN	
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19 HN Tapping	Depth = 17.2 HN
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 8/11/23	
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						Row = 16
2	External Relief Dia	6.5 HN	Outside (2-2)		Inner			
3	External Relief Depth		11 HN		5 HN			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		8	11	23			
	Inspected By (Sign) & Date		Ravi 8/11/23					

Reviewed by (Engineer-CNC) 8/11/23

Manager-QA

Scanned with CamScanner