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
Inprocess Inspection (Pellet Dies)		Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10622	45/50
2	Machined By		V.T.L M/c Shop	Drg No. L.S.D. 918
3	Pallet Die No.		8828 (3.5) MM	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 MM, Step OD = 709.9 MM	Tapper = 4°
6	Inside Diameter	Drg. No.	600.12 MM / 600.14 MM	Step length = 23.5
7	Width of Pellet Die	Drg. No.	250 MM	Undercut = 1.5 MM
8	Grooves as per Drawing	Drg. No.	24×5×9 MM / 24×5×9 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 = 12 Both Side
12	Tapping PCD		655 MM	
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 = 24.5 MM	Tapping Depth = 22.8 MM
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 = 37
2	External Relief Dia	4.0 MM	All Lines					
3	External Relief Depth		5 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		8	11	23			
	Inspected By (Sign) & Date		Ravi 8/11/23					

8/11/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner