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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.		10764	35/50
2	Machined By		V.T.L N/C Shop	Dwg No: LEC2980 Rev.00
3	Pallet Die No.		9427 (3.2) HH	
4	Die Category	Drg. No.	Carbaside	
5	Out Side Diameter	Drg. No.	6 Deg, Step OD, Tapper=12° Step length 18.5	
6	Inside Diameter	Drg. No.	5 20.12 HH	
7	Width of Pellet Die	Drg. No.	8.22 HH	
	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		56.5 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 = 18.8 HH	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Rao 17/11/23	
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						Rao 37
2	External Relief Dia	3.8 HH	Outside (3.3)		Inner			
3	External Relief Depth		21 HH		15 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		17	11	23			
	Inspected By (Sign) & Date		Rao 17/11/23					

Rao 17/11/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner