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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.		10641	40/40
2	Machined By		V.T.L. H/C Shop	Dy No. Lark 3195 3210
3	Pallet Die No.		1078 08 (5.0) MM	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 MM Step OD = 491 MM	Step length 17.5 MM
6	Inside Diameter	Drg. No.	420.12 MM / 420.14 MM	
7	Width of Pellet Die	Drg. No.	158 MM	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 MM / 12 x 8 x 3 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No of Holes = 8 Both Side
12	Tapping PCD		454 MM / 453.9 MM	
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 19.8 MM Tapping Depth = 17.4 MM	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ravi 16/11/23	
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						Ravi 17
2	External Relief Dia	5.5 MM	Outside (2-2)		Inner			
3	External Relief Depth		5 MM		Nill			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		16	11	23			
	Inspected By (Sign) & Date		Ravi 16/11/23					

16/11/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner