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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.		10617	45/50
2	Machined By		V.T.L. H/C Shop	Dy No. 1.S.O. 779 Rev. 00
3	Pallet Die No.		10925 (6.0) HH	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	410 HH, Step OD: 388 HH, Step length 9.5	
6	Inside Diameter	Drg. No.	310.12 HH	
7	Width of Pellet Die	Drg. No.	146 HH	
8	Grooves as per Drawing	Drg. No.	15 x 8 x 3 HH / 15 x 8 x 3 HH	
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: 4 Both Side
12	Tapping PCD		352 HH	
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: 25.5 HH Tapping Depth: 23.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 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						Ravi 12
2	External Relief Dia	6.3 HH	Outside (2-2)		Inner			
3	External Relief Depth		11 HH		5 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		17	11	23			
	Inspected By (Sign) & Date		Ravi 17/11/23					

Sahi 17/11/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner