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.		9763	27/48
2	Machined By		V.T.L H/C Shop	Dy No. 18.0.516 Rev 2.00
3	Pallet Die No.		9055 (3.0) MM	
4	Die Category	Drg. No.	55370	
5	Out Side Diameter	Drg. No.	615.5 MM (A) Step OD = 613.3 MM / 612.4 MM	
6	Inside Diameter	Drg. No.	580.12 MM	Step length = 19.4 (A)
7	Width of Pellet Die	Drg. No.	185.9 MM (A)	
8	Grooves as per Drawing	Drg. No.	13x8x2.9 MM (A) / 13x8x3 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 = 12 Both Side
12	Tapping PCD		565 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 = 20.4 MM, Tapping Depth = 18.2	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 29/6/23	
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 — 1 Hole Closed (A)	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	Ok						Rev = 3.0
2	External Relief Dia	3.5 MM	Outside (3-3)		Inner			
3	External Relief Depth		24 MM		21 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		29	6	23			
	Inspected By (Sign) & Date		Ravi 29/6/23					

29/6/23

Reviewed by (Engineer-CNC)

Manager-QA