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.		10739/	44/55
2	Machined By		V.T.L. N/C. Shop	Drg No. L-8.0.453 Rev 2
3	Pallet Die No.		10777 (4.0)	
4	Die Category	Drg. No.	JEN	
5	Out Side Diameter	Drg. No.	740 HH Step OD = 743.5 HH	Tapper 10°
6	Inside Diameter	Drg. No.	630.12 HH	Step length, 23
7	Width of Pellet Die	Drg. No.	290 HH	Under cut = 1.75
8	Grooves as per Drawing	Drg. No.	15x8x5 HH / 15x8x5 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 16 Both Side
12	Tapping PCD		685 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		Ravi 25/11/23	
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 - 2 Hole Closed (A)	

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

1	Counter Sinking Depth & Finish	Ok						Rev=53
2	External Relief Dia	4.5 HH	OD Side (3-3)		Inner			
3	External Relief Depth		19 HH		11 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		25	11	23			
	Inspected By (Sign) & Date		Ravi 25/11/23					

Satya 25/11/23
Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner