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.		10620	210/65
2	Machined By		V.T.L. H/C Shop	35/65
3	Pallet Die No.		11185(10.0) HH	Dy No. LB.D. 788 Rev.01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	678 HH, Step OD = 693 HH	Tapper = 8°
6	Inside Diameter	Drg. No.	548.12 HH	Step length. 38 HH
7	Width of Pellet Die	Drg. No.	195 HH	Undercut = 2.35 HH
8	Grooves as per Drawing	Drg. No.	31x8x8 HH / 31x8x8 HH	5x8 HH Face Side Step 1 HH Deep Both Side
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 2 Both Side
12	Tapping PCD		619 HH	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth. 38.6 HH Tapping Depth. 30.7	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Rao 24/11/23	
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. 8
2	External Relief Dia	11.0 HH	1st Rad 11.0 HH All Lines		11rd Rad 11.0 HH All Lines			
3	External Relief Depth		25 HH		30 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		24	11	23			
	Inspected By (Sign) & Date		Rao 24/11/23					

Reviewed by (Engineer-CNC) 24/11/23

Manager-QA

Scanned with CamScanner