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.		10698	48/55
2	Machined By		V.T.L N/C Shop	Dy no. 18.0.922
3	Pallet Die No.		11151 (6.0) MM	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	630 MM, Step OD = 624 MM	Tapper = 12°
6	Inside Diameter	Drg. No.	520.12 MM	Step length = 20 MM
7	Width of Pellet Die	Drg. No.	222 MM	
8	Grooves as per Drawing	Drg. No.	13x8x5 MM / 13x8x5 MM	
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 = 12 Both side
12	Tapping PCD		565 MM	
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 = 21.3 MM	Tapping Depth = 19 MM
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Rajoi 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						Rajoi 23
2	External Relief Dia	6.5 MM	Outside (3-3)		Inner			
3	External Relief Depth		19 MM		13 MM			
4	Inspection Done Before Hardening By (Name)		Rajoi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		24	11	23			
	Inspected By (Sign) & Date		Rajoi 24/11/23					

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

Manager-QA

Scanned with CamScanner