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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.		9828	39/48
2	Machined By		V.T.L. N/C Shop	Drg No = L.S.D.757 Rev = 00
3	Pallet Die No.		8812 (3.0) HH	
4	Die Category	Drg. No.	NJEW	
5	Out Side Diameter	Drg. No.	696 HH Step OD = 703 HH	Step length = 24 HH
6	Inside Diameter	Drg. No.	600.12	Tapper = 12°
7	Width of Pellet Die	Drg. No.	265 HH	Undercut = 3.5 HH
8	Grooves as per Drawing	Drg. No.	15x8x7 HH / 15x8x7 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		640 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 = 18.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 1/7/23	
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 Colused (C)	

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

1	Counter Sinking Depth & Finish	ok							Rev = 46
2	External Relief Dia	3.5 HH	Outside (3-3)		Inner				
3	External Relief Depth		15 HH		9 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		1	7	23				
	Inspected By (Sign) & Date		Ravi 1/7/23						

1/7/23

Reviewed by (Engineer-CNC)

Manager-QA