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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.		10772	35/40
2	Machined By		V.T.L. M/c Shop	Dy No. 1.S.No. 865 Rs 0.700
3	Pallet Die No.		11167 (4.5) MM	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	390 MM Step OD 383 MM	Step length 11.5
6	Inside Diameter	Drg. No.	310.12 MM	
7	Width of Pellet Die	Drg. No.	135 MM	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 MM | 12 x 8 x 3 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		M/c Shop	Tapping No of Holes 8 Both Side
12	Tapping PCD		350 MM | 349.9 MM	
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Roll	
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		Ravi 9/12/23	
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						Rs 15
2	External Relief Dia	5.0 MM	Outside (2-2)		Inner			
3	External Relief Depth		9 MM		5 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		9	12	23			
	Inspected By (Sign) & Date		Ravi 9/12/23					

Reviewed by (Engineer-CNC) 9/12/23

Manager-QA

Scanned with CamScanner