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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.: 18.0-865 Rev: 00
3	Pallet Die No.		11125 (4.5) HH	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	390 HH Step OD = 383 HH Step length 11.5	
6	Inside Diameter	Drg. No.	310.12 HH	
7	Width of Pellet Die	Drg. No.	135 HH	
8	Grooves as per Drawing	Drg. No.	12x8x3 HH / 12x8x3 HH	
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		349.9 HH	
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.3 HH Tapping Depth = 19 HH	
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							Row = 15
2	External Relief Dia	50 HH	OD Side (2-2)		Inner				
3	External Relief Depth		9 HH		5 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		9	12	23				
	Inspected By (Sign) & Date		Ravi 9/12/23						

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

Manager-QA

Scanned with CamScanner