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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.		10845	36/50
2	Machined By		V.T.L. N/C Shop	Drg No. I.E.C. 9980 Rev 05
3	Pallet Die No.		11105 (3.0) HH	
4	Die Category	Drg. No.	Ext wide	
5	Out Side Diameter	Drg. No.	620 HH, Step OD, Tapper, 12° Step length 18.5	
6	Inside Diameter	Drg. No.	520.12 HH	
7	Width of Pellet Die	Drg. No.	222 HH	
8	Grooves as per Drawing	Drg. No.	13x8x 5 HH / 13x8x 5HH	
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 HH	
13	Tapping Hole Diameter		M20 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 21.4 HH Tapping	Depth. 19 HH
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Rao 11/12/23	
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							Rao 38
2	External Relief Dia	3.5 HH	Outside (3-3)		Inner				
3	External Relief Depth		20 HH		14 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		11	12	23				
	Inspected By (Sign) & Date		Rao 11/12/23						

Reviewed by (Engineer-CNC) 11/12/23

Manager-QA

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