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
Inprocess Inspection (Pellet Dies)		Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10846	33/40
2	Machined By		V.T.L M/C Shop	Drg No. 15.0.495 Rev. 00
3	Pallet Die No.		10403	
4	Die Category	Drg. No.	38 D	
5	Out Side Diameter	Drg. No.	500 MM Step OD = 491 MM	Step length 16.5
6	Inside Diameter	Drg. No.	420.12 MM	
7	Width of Pellet Die	Drg. No.	173 MM	
8	Grooves as per Drawing	Drg. No.	10x8.5x5 MM / 10x8.5x5 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		454.9 MM / 455 MM	
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 21.4 MM	Tapping Depth 19 MM
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 15/12/23	
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						Ravi 98
2	External Relief Dia	3.3 MM	Outside (2-2)		Inner			
3	External Relief Depth		13 MM		7 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		15	12	23			
	Inspected By (Sign) & Date		Ravi 15/12/23					

Reviewed by (Engineer-CNC) 15/12/23

Manager-QA

Scanned with CamScanner