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.		10866	45/55
2	Machined By		V.T.L N/C Shop	Dy No. 1.8.0 = 930 Rev. 00
3	Pallet Die No.		10884 (8.0) HH	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	530 HH Step OD = 492 HH Step length = 16.5	
6	Inside Diameter	Drg. No.	420.12 HH	
7	Width of Pellet Die	Drg. No.	160 HH	
8	Grooves as per Drawing	Drg. No.	10x8x5 HH / 10x8x5 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. 8 Both Side
12	Tapping PCD		454 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. 18.9 HH Tapping Depth = 17 HH	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ravi 13/12/23	
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 13
2	External Relief Dia	8.5HH	outside (3-32)		Inner			
3	External Relief Depth		18 HH		10HH			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		13	12	23			
	Inspected By (Sign) & Date		Ravi 13/12/23					

Sahil 13/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner