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.		10887	99/40
2	Machined By		V.T.L. H/C Shop	Drg No: Lark 3195 S10
3	Pallet Die No.		10927 (3.0) HH	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 HH, Step OD = 491HH	Step length. 17.5HH
6	Inside Diameter	Drg. No.	420.12 HH	
7	Width of Pellet Die	Drg. No.	158 HH	
8	Grooves as per Drawing	Drg. No.	12+8+3 HH / 12+8+3 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No of holes = 8 Both Side
12	Tapping PCD		454 HH	
13	Tapping Hole Diameter		H20; Check by H2 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 19.3HH Tapping Depth = 17.1HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 14/12/23	

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							Rows = 24
2	External Relief Dia	3.5HH	Outside (2.2)		Inner				
3	External Relief Depth		14HH		11HH				
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		14	12	23				
	Inspected By (Sign) & Date		Ravi 14/12/23						

Sahil 14/12/23
Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner