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.		10803	40/40
2	Machined By		V.T.L H/c Shop	Drg No. LSD.905
3	Pallet Die No.		10934 (3.5) HH	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 HH Step OD = 491 HH	Step length = 17.5 HH
6	Inside Diameter	Drg. No.	480.12 HH	
7	Width of Pellet Die	Drg. No.	158 HH	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 HH / 12 x 8 x 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		Ø3/4" = Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.2 HH Tapping	Depth = 17.2 HH
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 - 1 Hole Closed (A)	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Rev. 98
2	External Relief Dia	3.0 HH	Outside (2-2)		Inner			
3	External Relief Depth		5 HH		Nill			
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					

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

Manager-QA

Scanned with CamScanner