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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.		10376	33/50
2	Machined By		V.T.L. M/c. Shop	Dwg No. LEC/2501
3	Pallet Die No.		9976 (4.0) HH	Rev. 01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	700 HH, Step OD = 693 HH	Tapper 12°, Step length = 2 HH
6	Inside Diameter	Drg. No.	600.12 HH	
7	Width of Pellet Die	Drg. No.	222 HH	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 HH / 12 x 8 x 7 HH	
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 = 12 Both Side
12	Tapping PCD		640 HH	
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 21 HH Tapping	Depth = 19 HH
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ravi 20/12/23	
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							Row = 32
2	External Relief Dia	4.5 HH	O.D Side (3-3)		Inner				
3	External Relief Depth		16 HH		12 HH				
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		20	12	23				
	Inspected By (Sign) & Date		Ravi 20/12/23						

20/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner