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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.		10867	32/52
2	Machined By		V.T.L H/C Shop	Dy No. 1.3.0.670 Rev. 00
3	Pallet Die No.		11536 (3.0) HH	
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	760 HH / Step OD = 803 HH	Tapper = 10°
6	Inside Diameter	Drg. No.	660.12 HH	Step length = 33 HH
7	Width of Pellet Die	Drg. No.	290 HH	Under cut = 31.5
8	Grooves as per Drawing	Drg. No.	27 x 8 x 7.5 HH / 27 x 8 x 7.5 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 12 Both Side
12	Tapping PCD		724 HH	
13	Tapping Hole Diameter		M22 = Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth 30 HH Tapping	Depth = 27.7 HH
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 25/12/23	
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 — 4 Hole Closed (A)	

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

1	Counter Sinking Depth & Finish	Ok						Ram 48
2	External Relief Dia	3.5 HH	Outside (3-31)		Inner			
3	External Relief Depth		21 HH		18 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		25	12	23			
	Inspected By (Sign) & Date		Ravi 25/12/23					

Satya 25/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner