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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.		10895	28/40/53
2	Machined By		V.T.L H/C Shop	Drg No: 1.3.0.632 Rev: 00
3	Pallet Die No.		11364 (5.0) HH	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	686 HH, Step OD: 684 HH	Step length: 18 HH
6	Inside Diameter	Drg. No.	520.12 HH	Taper: 12°
7	Width of Pellet Die	Drg. No.	222 HH	
8	Grooves as per Drawing	Drg. No.	13x8x5 HH / 13x8x5 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		565 HH	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 21.3 HH Tapping	Depth: 19 HH
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 16/12/23	
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 2 & 6
2	External Relief Dia	5.5HH / 6.0HH	5.5 HH	All Lines	6.0HH	All Lines		
3	External Relief Depth		25 HH			13 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		16	12	23			
	Inspected By (Sign) & Date		Ravi 16/12/23					

Satya 16/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner