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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.		10884	50/50
2	Machined By		V.T.L. M/c Shop	Dig No: 1.S.9.415
3	Pallet Die No.		11335 (6.0) HH	Rev: 01
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 HH, Step OD = 496.4 HH / 499 HH	Tapper: 12°
6	Inside Diameter	Drg. No.	420.12 HH	Step length: 20 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		M/c Shop	Tapping No of H.les: 8 Both Side
12	Tapping PCD		454 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: 19.4 HH Tapping Depth = 17.1 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Rao 5/1/24	
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						Counter: 60° Dia: 15
2	External Relief Dia	6.3 H	Outside (2-2)		Inner			
3	External Relief Depth		4 HH		Nill			
4	Inspection Done Before Hardening By (Name)		Rao					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		5	1	24			
	Inspected By (Sign) & Date		Rao 5/1/24					

Satya 5/01/24
Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner