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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.		11177	27/37/50
2	Machined By		V.T.L. M/C Shop	Dy No. 1.8.92.493 Rev. 00
3	Pallet Die No.		11906 (4.0) HH	
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 HH, Step Dia 692.8 HH	Tapper = 12° Step length = 13.8
6	Inside Diameter	Drg. No.	600.12 HH	
7	Width of Pellet Die	Drg. No.	999 HH	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 HH / 12x10x7.5 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 = 21.3 HH Tapping Depth = 19 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 20/1/24	
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°					Rev. 31
2	External Relief Dia	4.3 HH / 4.5 HH	4.3 HH All Lines		4.5 HH	All Lines		
3	External Relief Depth		23 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		20	1	24			
	Inspected By (Sign) & Date		Ravi 20/1/24					

20/1/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner