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.		11117	23/50
2	Machined By		V.T.L. M/c Shop	Drg No: 13.D.322
3	Pallet Die No.		11699 (4.0) HH	Rev: 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 HH, Step OD 500 HH	Step length = 8 HH
6	Inside Diameter	Drg. No.	480.12 HH	Tapper 10°
7	Width of Pellet Die	Drg. No.	158 HH	
8	Grooves as per Drawing	Drg. No.	12×8×3 HH / 12×8×3 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 holes 8 Both Side
12	Tapping PCD		455 HH / 454.9 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 = 18.8 HH Tapping Depth = 16.8 HH	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 3/2/24	
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° Ravi 2
2	External Relief Dia	4.5 HH	Outside 2-22		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		3	2	24				
	Inspected By (Sign) & Date		Ravi 3/2/24						

Reviewed by (Engineer-CNC) 3/2/24

Manager-QA

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner