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.		11185/	44/50/ 13355
2	Machined By		V.T.L N/C Shop	Dy No: Lark 5310
3	Pallet Die No.		11607 (4.0) HH/	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	600 HH/ Step OD: 612 HH/	Step length 19.4 HH
6	Inside Diameter	Drg. No.	508.12 HH	
7	Width of Pellet Die	Drg. No.	228 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		N/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: 21.4 HH Tapping Depth: 18 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ravi 31/1/24	
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 — Counter = 60°

1	Counter Sinking Depth & Finish	OK						Ravi 31
2	External Relief Dia	4.5 HH	Out Side (3-3)		Inner			
3	External Relief Depth		14 HH		6 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		31	1	24			
	Inspected By (Sign) & Date		Ravi 31/1/24					

Reviewed by (Engineer-CNC) 31/1/24

Manager-QA

Scanned with CamScanner