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.		10824,	75/75
2	Machined By		N.T.L N/C Shop	Dy No. 18.0.691 Rev 00
3	Pallet Die No.		11773 (8.0) MM,	
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1061 MM, Step OD = 1041 MM	Tapper 4°
6	Inside Diameter	Drg. No.	911.12 MM	Step length = 39 MM
7	Width of Pellet Die	Drg. No.	388 MM	
8	Grooves as per Drawing	Drg. No.	33x10x10 MM / 33x10x10 MM	
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 - 16 Both Side
12	Tapping PCD		975 MM,	
13	Tapping Hole Diameter		M24 x Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth = 48.4 MM Tapping Depth = 38.3	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 1/2/24	
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 — Counter = 60°

1	Counter Sinking Depth & Finish	Ok						Rad = 3
2	External Relief Dia	9.0 MM	Outside 2-3		Inner			
3	External Relief Depth		8 MM		Nill			
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		1	2	24			
	Inspected By (Sign) & Date			Ravi 1/2/24				

Satya 1/2/24
Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner