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.		11200	50/60
2	Machined By		V.T.L M/c Shop	Drg No. 1.8.0 = 409
3	Pallet Die No.		10202 (4.0) MM	Rev = 00
4	Die Category	Drg. No.	33370	
5	Out Side Diameter	Drg. No.	639.8 MM Step OD = 612 MM	Step length = 19.4
6	Inside Diameter	Drg. No.	520.12 MM	
7	Width of Pellet Die	Drg. No.	186 MM	
8	Grooves as per Drawing	Drg. No.	13×8×3 MM / 13×8×3 MM	
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		565 MM	
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 MM	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 2/2/24	
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						Row = 25
2	External Relief Dia	4.5 MM	Outside 3.3		Inner			
3	External Relief Depth		18 MM		10 MM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		2	2	24			
	Inspected By (Sign) & Date		Ravi 2/2/24					

Satya 2/2/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner