Lark Engineering Company (India) Pvt. Ltd.	Form No.	CNC/QA/FM/02
I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)	Rev. No.	01
Inprocess Inspection (Pellet Dies)	Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11219	30/55/75
2	Machined By		V.T.L M/C Shop	Drg No. 13.D= 324
3	Pallet Die No.		10371 (6.0) MM	Rev= 00
4	Die Category	Drg. No.	NTED	
5	Out Side Diameter	Drg. No.	722 MM/734 Step OD=777 MM/778 MM/675 MM	
6	Inside Diameter	Drg. No.	572.12 MM	Step length= 42 MM
7	Width of Pellet Die	Drg. No.	270 MM	24.5 ⌒ 24.5 21 MM
8	Grooves as per Drawing	Drg. No.	88×8×12 MM / 106×8×12 MM	Udercut= 27.5
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 6
12	Tapping PCD		660 MM	
13	Tapping Hole Diameter		@3/4" = Check by @3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and IInd Side One Slot	
15	Tapping Hole Depth		Drill Depth= 36.4 MM	Tapping Depth= 33.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 3/2/24	1 Slot 39 MM width 26 MM Deep
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° Row= 7
2	External Relief Dia	6.5 MM / 7.0 MM	6.5 MM All Rows		7.0 MM All Rows			
3	External Relief Depth		45 MM			20 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		3	2	24			
	Inspected By (Sign) & Date		Ravi 3/2/24					

3/2/24

Reviewed by (Engineer-CNC) Manager-QA

Scanned with CamScanner