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.		11252	30/40/9189
2	Machined By		V.T.L. M/c Shop	Dy No. Lark SS90
3	Pallet Die No.		11578 (5.0) HH	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 HH, Step OD. 395 HH	Step length. 14.5
6	Inside Diameter	Drg. No.	320.12 HH	
7	Width of Pellet Die	Drg. No.	142 HH	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 HH / 15.5 x 7 x 2 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		355 HH	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth. 21.4 HH Tapping Depth - 19 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 13/2/24	
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° Row - 14
2	External Relief Dia	5.5 HH	Outside (2.2)		Inner			
3	External Relief Depth		1.5 HH		1 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		13	2	24			
	Inspected By (Sign) & Date		Ravi 13/2/24					

Satya 13/2/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner