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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.		11386	40/55
2	Machined By		V.T.L M/c Shop	Dy No. 1.3.0.557 Rev. 00
3	Pallet Die No.		11084 (6.0) HH	
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	630 HH, Step OD = 623.8 HH	Tapper = 12°
6	Inside Diameter	Drg. No.	520.14 HH (A)	Step length 2 HH
7	Width of Pellet Die	Drg. No.	188 HH	
8	Grooves as per Drawing	Drg. No.	12×10×5 HH | 12×10×5 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: 12 Both Side
12	Tapping PCD		565 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: 20.8 HH, Tapping Depth: 18 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Rai 15/3/24	
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° Rev = 18
2	External Relief Dia	6.3 HH	Out Side 63.37		Inner			
3	External Relief Depth		2 HH		15 HH			
4	Inspection Done Before Hardening By (Name)		Rai					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		15	3	24			
	Inspected By (Sign) & Date		Rai 15/3/24					

Reviewed by (Engineer-CNC) 15/3/24

Manager-QA

Scanned with CamScanner