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.		11345	33/60
2	Machined By		V.T.L N/C Shop	Drg No. 1-8.0.654
3	Pallet Die No.		11564 (6.0) HH	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	720 HH, Step OD. 692 HH	Step length 19.5
6	Inside Diameter	Drg. No.	600.12 HH	
7	Width of Pellet Die	Drg. No.	222 HH	
8	Grooves as per Drawing	Drg. No.	36x10x7 HH / 36x10x7 HH	
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 - 12 Both Side
12	Tapping PCD		645 HH	
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. 20.8 HH Tapping Depth - 18.8 HH	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 18/3/24	
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° Row 16
2	External Relief Dia	7.0 HH		All Rows				
3	External Relief Depth			27 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		18	3	24			
	Inspected By (Sign) & Date		Ravi 18/3/24					

12/3/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner