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.		9891	34/48
2	Machined By		V.T.L M/c Shop	Drg No: 13.0.490 Rev: 00
3	Pallet Die No.		9817 (3.0)MM	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 MM Step OD = 491 MM	Step length: 17.4
6	Inside Diameter	Drg. No.	420.12 MM	
7	Width of Pellet Die	Drg. No.	157.9 MM	
8	Grooves as per Drawing	Drg. No.	12×8×3 MM / 12×8×3MM	
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		457	
13	Tapping Hole Diameter		03/4" - Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4MM Tapping Depth: 18.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Rao: 17/7/23	
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						Rev: 25
2	External Relief Dia	3.5MM	OD Side (2-2)		Inner			
3	External Relief Depth		12MM		6MM			
4	Inspection Done Before Hardening By (Name)		Rao:					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		17	7	23			
	Inspected By (Sign) & Date		Rao: 17/7/23					

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner