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.		11317	45/60
2	Machined By		V.T.L. H/C Shop	Dy No. 1-8-0, 584
3	Pallet Die No.		12232 (8.0) HH	Rev. 01
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 HH, Step OD = 798 HH	Tapper 4°
6	Inside Diameter	Drg. No.	660.12 HH	Step length 25.5
7	Width of Pellet Die	Drg. No.	324 HH	Undercut = 9 HH
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 HH / 21.5 x 8 x 10 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No of holes 12 Both Side
12	Tapping PCD		725 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, 30.8 HH	Tapping Depth 28.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 28/3/24	
1	As per programme no.			8 Slot 32.1 HH width 8 HH Deep Both Side
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

Counter 60°

1	Counter Sinking Depth & Finish	ok						Rev. 07
2	External Relief Dia	8.5 HH	Outside 783.31		Inner			
3	External Relief Depth		23 HH		15 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		28	3	24			
	Inspected By (Sign) & Date		Ravi 28/3/24					

Satya 28/3/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner