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.		11509/	30/45/
2	Machined By		V.T.L M/c Shop	By Hand 13.02483
3	Pallet Die No.		11753 (5.0) HH/	PD-03/
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4.00 HH/ Step OD = 38 HH/	Step length 10.4
6	Inside Diameter	Drg. No.	30.12 HH/	
7	Width of Pellet Die	Drg. No.	134.1 HH/	
8	Grooves as per Drawing	Drg. No.	8x7x3 HH/ 8x7x3 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		350 HH/	
13	Tapping Hole Diameter		1/2" = Check by 1/2" Tap/	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth 17.4 HH Tapping Depth = 15 HH	
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.		—	
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 Sink Depth = 1.5
2	External Relief Dia	5.5 HH/	All Rows						
3	External Relief Depth			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