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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.		9651	37/50
2	Machined By		V.T.L. M/c. Shop	Drg No. 1.8.0.71
3	Pallet Die No.		9936 (3.5) MM	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	690 MM Step OD = 691.8 MM (A)	Tapper = 12°
6	Inside Diameter	Drg. No.	520.12 MM	Step length 17 MM
7	Width of Pellet Die	Drg. No.	22.2 MM	Undercut = 0.9 MM
8	Grooves as per Drawing	Drg. No.	9x10x4 MM / 9x10x4 MM	
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 MM	
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: 20.5 MM Tapping Depth = 18.8 MM	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 1/6/23	
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 - 2 Hole Colosed (10)	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	Ok						Ravi 35
2	External Relief Dia	3.8 MM	Outside (3.3)		Inner			
3	External Relief Depth		17 MM		13 MM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		1	6	23			
	Inspected By (Sign) & Date		Ravi 1/6/23					

1/6/23

Reviewed by (Engineer-CNC)

Manager-QA