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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.		11572	42/55
2	Machined By		V.T.L. H/C Shop	Dy No. 1.S.D. 355
3	Pallet Die No.		11026 (4.0) HH	Rev. 00
4	Die Category	Drg. No.	SS37D	
5	Out Side Diameter	Drg. No.	630 HH, Step OD. 612 HH, Step length 4 mm	
6	Inside Diameter	Drg. No.	520.14 HH (B)	
7	Width of Pellet Die	Drg. No.	196 HH,	
8	Grooves as per Drawing	Drg. No.	13×8×3 HH / 13×8×3 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		565 HH	
13	Tapping Hole Diameter		M20 x 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
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 30/3/24	
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						Ra = 25
2	External Relief Dia	4.5 HH	Out Side (B-3)		Inner			
3	External Relief Depth		1.7 HH		1.3 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		30	3	24			
	Inspected By (Sign) & Date		Ravi 30/3/24					

Satya 30/3/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner