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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.		11590	28/40
2	Machined By		V.T.L.H/c Shop	Dr. No. 68.02 81
3	Pallet Die No.		11296 (2-5)H	Rev. 01
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H, Step 002 499 H	Step length 17
6	Inside Diameter	Drg. No.	420.12 H	
7	Width of Pellet Die	Drg. No.	158 H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H / 12x8x3 H	
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 8 Both side
12	Tapping PCD		454 H	
13	Tapping Hole Diameter		Ø3/4" - Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19 H Tapping Depth 16.8 H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/4/24

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 60	
2	External Relief Dia	2.8 H	Outside (2.2)	Inner			Rev. 2 98	
3	External Relief Depth		18 H	18 H				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		3	4	24			

Inspected By (Sign) & Date

Ravi 31/4/24

Reviewed by (Engineer-CNC)

Manager-QA