8449

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.		13099	26/66
2	Machined By		V.T.L M/c Shop	32/66
3	Pallet Die No.		13324 (6.0) MM	Drg No. (3.0, 6.0)
4	Die Category	Drg. No.	H. Jumbo	Row, 02
5	Out Side Diameter	Drg. No.	680.7 MM, Step OD, 693 MM	Tapper, 8°
6	Inside Diameter	Drg. No.	548.12 MM	Step length, 31 MM, 31.3 MM
7	Width of Pellet Die	Drg. No.	195 MM	Under cut, 2.5 MM
8	Grooves as per Drawing	Drg. No.	32x7x8 MM / 32x7x8 MM, (4x3) MM	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step 2 MM Deep Both side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619 MM	Tapping No of Holes, 2 Both Side
13	Tapping Hole Diameter		M16, Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 33.6 MM	Tapping Depth, 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 30/10/24	
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, 30° Row, 12
2	External Relief Dia	7.0 MM	1st Pad 7.0 MM, 40 MM		2nd Pad 7.0 MM, 34 MM			
3	External Relief Depth							
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	10	24			
	Inspected By (Sign) & Date		Ravi 30/10/24					

Satyam 30/10/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner