8489

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.		13165	40/40
2	Machined By		V.T.L H/C Shop	Dy No. 218.474
3	Pallet Die No.		12529 (4.0) HH	Rack No
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	391 HH Step OD. 388HH, Step length 9.4	
6	Inside Diameter	Drg. No.	one side ID Step 310.12 HH | 311.12 HH	
7	Width of Pellet Die	Drg. No.	146 HH	
8	Grooves as per Drawing	Drg. No.	15x8x3 HH | 15x8x3 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	Tapping No of holes 8 Both Side
11	Tapping Operator		H/C Shop	
12	Tapping PCD		356 HH	
13	Tapping Hole Diameter		ø3/4" | ø1/2" Check by ø3/4 Butt ø1/2 Tap	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping ø3/4 and IInd Side ø1/2	
15	Tapping Hole Depth		Drill Depth 18.4HH Tapping Depth 16.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 6/11/24	
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

Counter 6 Rev: 17

1	Counter Sinking Depth & Finish	Ok						
2	External Relief Dia	4.5HH	Outside 22.29		Inner			
3	External Relief Depth		4HH		Mill			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		6	11	24			
	Inspected By (Sign) & Date		Ravi 6/11/24					

Satya 6/11/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner