8618

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.		13238	Go/655
2	Machined By		V.T.L H/C Shop	Dgn No: 13.0.902
3	Pallet Die No.		13782 (12.0) HH	Rev. 02
4	Die Category	Drg. No.	539-TD	
5	Out Side Diameter	Drg. No.	639.7 HH	Step OD: 641.7 HH / 652.3 HH
6	Inside Diameter	Drg. No.	508.8 HH / Step ID: 539.5 / 520.1 HH	Tapper: 8°
7	Width of Pellet Die	Drg. No.	17.5 HH	Step length: 32 HH
8	Grooves as per Drawing	Drg. No.	30x21x7.25 HH / 9x2.5 HH	Undercut: 1 HH / 30 HH
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	Face Side Step 0.5 HH Deep
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		H/C Shop	Tapping No of holes: 4
12	Tapping PCD		574 HH	
13	Tapping Hole Diameter		M16: Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and Third	Side: 4 Slot
15	Tapping Hole Depth		Drill Depth: 30.4 HH Tapping Depth: 28.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 25/11/24	
1	As per programme no.		—	4 Slot
2	Gun Drilling Work Completed On		—	51.5 long
3	Hole Finish In Gun Drilling	Marked	Ok	28 HH wide
4	Defective Holes (If Any)		No	15 HH Deep

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

1	Counter Sinking Depth & Finish	Ok		Counter 60° Rows 5
2	External Relief Dia	12.5 HH	All Rows	
3	External Relief Depth		5.5 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		25 / 11 / 24	
	Inspected By (Sign) & Date		Ravi 25/11/24	

Satya 25/11/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner