8620

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.		13407	~~[illegible]~~
2	Machined By		V.T.L. M/c Shop	30/45
3	Pallet Die No.		13857 (5.0) MM	Drg No. LS.D.483
4	Die Category	Drg. No.	Junior	Rev. 03
5	Out Side Diameter	Drg. No.	400 MM, Step OD. 387 MM	Step length 10.5
6	Inside Diameter	Drg. No.	310.12 MM	
7	Width of Pellet Die	Drg. No.	134 MM	
8	Grooves as per Drawing	Drg. No.	8x7x3 MM / 8x7x3 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No. of Holes. 8 Both Side
12	Tapping PCD		350 MM	
13	Tapping Hole Diameter		1/2" = Check by 1/2" Tap	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 16.3 MM Tapping Depth. 14.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 2/12/24	
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° Row = 15
2	External Relief Dia	5.5 MM	Outside (2-2)		Inner			
3	External Relief Depth		20 MM		15 MM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		2	12	24			
	Inspected By (Sign) & Date		Ravi 2/12/24					

Satyam 2/12/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner