8676

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.		13480	38/50
2	Machined By		V.T.L. N/C Shop	Drg No: L.S.D. 978 Rev.01
3	Pallet Die No.		13177 (6.0) HH	
4	Die Category	Drg. No.	SED	
5	Out Side Diameter	Drg. No.	520.2 HH Step OD2 491.5 HH	Step length 19.5
6	Inside Diameter	Drg. No.	420.12 HH	
7	Width of Pellet Die	Drg. No.	182 HH	
8	Grooves as per Drawing	Drg. No.	12x8x3 HH / 12x8x3 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		N/C Shop	Tapping No of Holes: 8 Both Side
12	Tapping PCD		454 HH	
13	Tapping Hole Diameter		03/4" - Check by 03/4" B.H.	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth: 20.3 HH Tapping Depth: 18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 3/12/24	
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

Counter = 60°

1	Counter Sinking Depth & Finish	Ok						Rev: 18
2	External Relief Dia	8.5 HH	Outside (12.2)		Inner			
3	External Relief Depth		20 HH		12 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		3	12	24			
	Inspected By (Sign) & Date		Ravi 3/12/24					

Satya 3/12/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner