5993

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.		INV	36/50
2	Machined By		V.T.L. M/c Shop	Drg No: L.E.C: 9980
3	Pallet Die No.		10555 (3.0) MM	Rev: 00
4	Die Category	Drg. No.	Extrawide.	
5	Out Side Diameter	Drg. No.	620 MM Step OD: Tapper: 12° Step length: 18.5	
6	Inside Diameter	Drg. No.	520.2 MM	
7	Width of Pellet Die	Drg. No.	222.1 MM (D)	
8	Grooves as per Drawing	Drg. No.	13×8×4.8 MM / 13×8×5 MM (A)	
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: 12 Both Side
12	Tapping PCD		565 MM	
13	Tapping Hole Diameter		M20: Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 MM	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 24/8/23	
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 – 2 Hole Colused (D)	

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

1	Counter Sinking Depth & Finish	ok						Row: 38
2	External Relief Dia	3.3 MM	outside (3-3)		Inner			
3	External Relief Depth		20 MM		14 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		24	8	23			
	Inspected By (Sign) & Date		Ravi 24/8/23					

24/8/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner