8721

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.		13157	60/66
2	Machined By		V.T.L M/c Shop	Drg No. LEC29136
3	Pallet Die No.		13941(3.5)mm	Rev=01
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1032mm, Step OD, 1033mm	Tapper 3°
6	Inside Diameter	Drg. No.	900.14mm	Step length 37mm 37.2mm
7	Width of Pellet Die	Drg. No.	375mm	Under cut, 0.5mm
8	Grooves as per Drawing	Drg. No.	29.5×8×13mm / 29.5×8×13mm	
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 15 Both Side
12	Tapping PCD		970mm	
13	Tapping Hole Diameter		M24, Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 38.4mm	Tapping Depth 36.4mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 10/12/24	2 Slot 32.1mm width 7.5mm Deep Both Side
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						Row 59
2	External Relief Dia	4.0mm	Outside (4-4)		Inner			
3	External Relief Depth		13mm		6mm			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		10	12	24			
	Inspected By (Sign) & Date		Ravi 10/12/24					

Satya 10/12/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner