5999

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.		10040	37/45
2	Machined By		V.T.L. M/c Shop	Dig No: 1.3.0.364 Rev: 00
3	Pallet Die No.		10764 (6.0) mm	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 mm Stock OD 388 mm	Stock length 11.4
6	Inside Diameter	Drg. No.	310.12 mm	
7	Width of Pellet Die	Drg. No.	135.1 mm (A)	
8	Grooves as per Drawing	Drg. No.	12.1 x 8 x 3 mm / 12 x 8 x 3 mm (B)	
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		ϕ3/4" Check by ϕ3/4" Roll	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth 20.8 mm	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Rajni 25/8/23	
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	

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

1	Counter Sinking Depth & Finish	Ok						Rev: 11
2	External Relief Dia	6.5 mm	Outside 12.2		Inner			
3	External Relief Depth		14 mm		8 mm			
4	Inspection Done Before Hardening By (Name)		Rajni					
5	Material Sent For Hardening By (Name)		Lark Forge					
6	Material Sent For Hardening On Date		25	8	23			
	Inspected By (Sign) & Date		Rajni 25/8/23					

25/8/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner