6000

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.		10128	36/46/52
2	Machined By		V.T.L M/c Shop	Drg No. 1.30.033
3	Pallet Die No.		9071 (4.0) mm	Rev. 01
4	Die Category	Drg. No.	33370	
5	Out Side Diameter	Drg. No.	620mm Step OD. 623.6mm	Tapper 12
6	Inside Diameter	Drg. No.	520.12 mm	Step length 20mm
7	Width of Pellet Die	Drg. No.	186 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
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		M16 Check by M16 Bold	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 26/8/23	
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. 25
2	External Relief Dia	4.5mm / 5.0mm	4.5mm All Lines		5.0mm All Lines			
3	External Relief Depth		14mm		4mm			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		26	8	23			
	Inspected By (Sign) & Date		Ravi 26/8/23					

26/8/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner