6998

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.		10158	15/40/60 ✓
2	Machined By		V.T.L. M/c Shop	Dy No. 1.S.O. 111
3	Pallet Die No.		10822 (6.0) MM / 6.5 MM (2-2)	Rev 00 ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 MM ✓ Step OD. 792 MM Step length 26.5	
6	Inside Diameter	Drg. No.	660.12 MM	Undercut 6 MM ✓
7	Width of Pellet Die	Drg. No.	32.4 MM ✓	
8	Grooves as per Drawing	Drg. No.	Ø1.5 × 8 × 8 MM / Ø1.5 × 8 × 8 MM ✓	
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		795 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. 31.2 MM Tapping Depth. Ø29.5 ✓	
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 SIDE 32.1 MM Wide 8 MM Deep Both Side ✓
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						Row = 34
2	External Relief Dia	6.5 MM / 7.0 MM	6.5 MM All Lines 7.0 MM (2-2) 45 MM		7.0 MM All Lines			
3	External Relief Depth				20 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		26	8	23			
	Inspected By (Sign) & Date		Ravi 26/8/23					

26/8/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner