9037

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 10140S6	39/50
2	Machined By		V.T.L M/c Shop	Dry Hole L.Z.C=9980
3	Pallet Die No.		13723(3.5)mm	Rou.00
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	619.9mm Step OD. Tapper 12°	
6	Inside Diameter	Drg. No.	520.12mm	Step length-18.5
7	Width of Pellet Die	Drg. No.	222mm	
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		565mm	
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 20.2mm Tapping Depth 18.6mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 21/1/25	
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						Row 38
2	External Relief Dia	3.8mm	outside (3-3)		Inner			
3	External Relief Depth		18mm		11mm			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		21	1	25			
	Inspected By (Sign) & Date		Ravi 21/1/25					

Satz 21/1/25.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner