6017

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.		10161	36/51
2	Machined By		V.T.L. H/C Shop	Drg No. LEC-1095 Rev. 02
3	Pallet Die No.		10261 (3.0) HH	
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	688 HH Tapper 12° Step length 32 HH	
6	Inside Diameter	Drg. No.	580.12 HH	
7	Width of Pellet Die	Drg. No.	266 HH	
8	Grooves as per Drawing	Drg. No.	28.5×6×12 HH / 28.5×6×12 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No of Holes 12 Both Side
12	Tapping PCD		630 HH	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 25.6 HH Tapping Depth 23.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 31/8/23	
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						Ravi 42
2	External Relief Dia	3.5 HH	Out Side (3.3)		Inner			
3	External Relief Depth		21 HH		15 HH			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		31	8	23			
	Inspected By (Sign) & Date		Ravi 31/8/23					

31/8/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner