6250

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.		10432	5150
2	Machined By		V.T.L N/C Shop	Dwg No: Lark 6355 3370
3	Pallet Die No.		10837 (2.3) HH	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 HH Step OD = 612 HH Step length =	9.5
6	Inside Diameter	Drg. No.	520.12 HH	
7	Width of Pellet Die	Drg. No.	222 HH	
8	Grooves as per Drawing	Drg. No.	13×8×5 HH / 13×8×5 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		N/C Shop	Tapping No of Holes 12 Both side
12	Tapping PCD		565 HH	
13	Tapping Hole Diameter		M20 × Check by M20 Roll	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth 20.4 HH Tapping Depth 18	(4)
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 12/10/23	
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 40
2	External Relief Dia	3.3 HH	OD Side (3.3)		Inner			
3	External Relief Depth		25 HH		19 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		12	10	23			
	Inspected By (Sign) & Date		Ravi 12/10/23					

Reviewed by (Engineer-CNC) 12/10/23

Manager-QA

Scanned with CamScanner