6239

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.		10447	32/38/50 Do accepted
2	Machined By		V.T.L M/c Shop	Drg No = L.S.D = 633
3	Pallet Die No.		10513 (4.0) MM	Rev = 01
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	620 MM, Step OD = 623.6 MM	Tapper = 12°
6	Inside Diameter	Drg. No.	520.12 MM	Step length = 20 MM
7	Width of Pellet Die	Drg. No.	186 MM	Udercut = 1.8 MM
8	Grooves as per Drawing	Drg. No.	13×8×5 MM / 13×8×5 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		565 MM	
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 = 20.4 MM Tapping Depth = 18.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 11/10/23	
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	

Discussed with Mr. Neeraj ji & Sumit ji (Sales)

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	4.5 MM / 5.0 MM	4.5 MM All Lines		5.0 MM All Lines			
3	External Relief Depth		18 MM		12 MM → conditionally accepted.			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		11	10	23			
	Inspected By (Sign) & Date		Ravi 11/10/23					

11/10/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner