6247

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.		10318	33/53/79
2	Machined By		V.T.L. N/C Shop	Dwg No. L.S.O.717 Rev. 01
3	Pallet Die No.		10384 (6.0) HH	
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1008 HH Step OD. 1023 HH	Tapper 3° Step length 41 Undercut 2.94
6	Inside Diameter	Drg. No.	850.1 HH	
7	Width of Pellet Die	Drg. No.	266 HH	
8	Grooves as per Drawing	Drg. No.	45×8×8 HH | 45×8×8 HH	Face Side Step 8 HH Deep Both side
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		935 HH	Tapping No of holes 8 Both Side
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 42.3 HH Tapping Depth 40.7 (A)	
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

Counter = 30° Rev 16

1	Counter Sinking Depth & Finish	Ok						
2	External Relief Dia	6.5HH | 7.0HH	6.5HH	All Lines	7.0HH	All Lines		
3	External Relief Depth		46HH			96HH		
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					

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

Manager-QA

Scanned with CamScanner