6248

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.		10415	50/55
2	Machined By		V.T.L. N/C Shop	Dg No. L.S.D. 903 Rev. 00
3	Pallet Die No.		10886 (10.0) HH	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	530 HH, Step OD. 498.88	Tapper 2 12
6	Inside Diameter	Drg. No.	480.12 HH	Step length. 18 HH
7	Width of Pellet Die	Drg. No.	158 HH	
8	Grooves as per Drawing	Drg. No.	18 x 8 x 3 HH / 12 x 8 x 3 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		454 HH	
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth. 19.8 HH Tapping Depth = 17.5	
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							Rev-8
2	External Relief Dia	10.5 HH	Outside (2-2)		Inner				
3	External Relief Depth		10 HH		5 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		13	10	23				
	Inspected By (Sign) & Date		Ravi 18/10/23						

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

Manager-QA

Scanned with CamScanner