6251

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.		10443	24/45
2	Machined By		V.T.L M/c Shop	Drg No: L.S.D.652
3	Pallet Die No.		9828 (3.0) mm	Rev: 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	690 mm Step OD: 693 mm	Tapper: 12°
6	Inside Diameter	Drg. No.	600.12 mm	Step length: 20 mm
7	Width of Pellet Die	Drg. No.	222 mm	Under cut: 1.5 mm
8	Grooves as per Drawing	Drg. No.	12x10x7.5 mm / 12x10x7.5 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		640 mm	
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: 20.4 mm	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 13/10/23	
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						Row: 38
2	External Relief Dia	3.5 mm	outside (3-3)		Inner			
3	External Relief Depth		24 mm		21 mm			
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 13/10/23					

13/10/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner