18-10-2023

6483

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.		10484	35/45
2	Machined By		V.T.L M/c Shop	Drg No. 1.EC.9747
3	Pallet Die No.		9830 (3.0) MM	Rev 01
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	Undercut = 1.5 MM
8	Grooves as per Drawing	Drg. No.	14x8x7 MM / 14x8x7 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 = 22.4 MM Tapping Depth = 20.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 18/10/23	
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		16 MM		10 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		18	10	23			
	Inspected By (Sign) & Date		Ravi 18/10/23					

Satya 18/10/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner