6259

Lark Engineering Company (India) Pvt. Ltd.	Form No.	CNC/QA/FM/02
I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)	Rev. No.	01
Inprocess Inspection (Pellet Dies)	Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10183	48/70
2	Machined By		V.T.L M/c Shop	Dy No. L.E.C/21/02
3	Pallet Die No.		11203 (4.0) MM	12008 Rev = 01
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1286.9 MM	Step OD = 1283 MM
6	Inside Diameter	Drg. No.	1145.1 MM	Step length = 22 MM
7	Width of Pellet Die	Drg. No.	388.5 MM	
8	Grooves as per Drawing	Drg. No.	26×6×13 MM | 26×6×13 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 = 20 Both Side
12	Tapping PCD		1210 MM	
13	Tapping Hole Diameter		M24 = Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 MM	Tapping Depth 31.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Rajoi 19/10/23	
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						Rejo = 56
2	External Relief Dia	4.8 MM	Outside (4-4)		Inner			
3	External Relief Depth		30 MM		22 MM			
4	Inspection Done Before Hardening By (Name)		Rajoi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		19	10	23			
	Inspected By (Sign) & Date		Rajoi 19/10/23					

Satya 19/10/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner