6336

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.		10534	40/50
2	Machined By		V.T.L N/C Shop	Drg No. L.E.C. 10295 Revised
3	Pallet Die No.		11114 (3.0) HH	
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 HH Step OD, Tapper 12°	
6	Inside Diameter	Drg. No.	580.12 HH	Step length 32
7	Width of Pellet Die	Drg. No.	266 HH	
	Grooves as per Drawing	Drg. No.	28.5×6×12 HH | 28.5×6×8 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		630 HH	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth 25.4 HH Tapping Depth 232	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Rani 28/10/23	
1	As per programme no.			
	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 = 42
2	External Relief Dia	3.5 HH	OD Side (3-3)		Inner			
3	External Relief Depth		16 HH		10 HH			
4	Inspection Done Before Hardening By (Name)		Rani					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		28	10	23			
	Inspected By (Sign) & Date		Rani 28/10/23					

Sahil 28/10/23
Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner