6323

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 M/C Shop	Drg No. L.E.C-10295
3	Pallet Die No.		11115 (3.0) MM	Rev. 02
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	682 MM, Step OD, Tapper 12°	
6	Inside Diameter	Drg. No.	580.12 MM	Step length, 32 MM
7	Width of Pellet Die	Drg. No.	266 MM	
8	Grooves as per Drawing	Drg. No.	28.5x6x12 MM / 28.5x6x12 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		630 MM	
13	Tapping Hole Diameter		M16, Chack by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 26.8 MM Tapping Depth, 24.5 MM	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 26/10/23	
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 42
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		26	10	23			
	Inspected By (Sign) & Date		Ravi 26/10/23					

Satya 26/10/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner