6859

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.		10614	40/50
2	Machined By		V.T.L M/c Shop	Drg No. 13.02.405
3	Pallet Die No.		14345 (3.5) MM	Rev=00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 MM / Step OD = 499 MM	Step length = 17 MM
6	Inside Diameter	Drg. No.	480.14 MM	Tapper = 12°
7	Width of Pellet Die	Drg. No.	158 MM	
	Grooves as per Drawing	Drg. No.	12×8×3.1 MM / 12×8×3.1 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, 8 Both Side
12	Tapping PCD		454 MM	
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 18.6 MM	Tapping Depth = 16.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 1/11/23	
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						Ravi 22
2	External Relief Dia	4.0 MM	outside (9.2)		Inner			
3	External Relief Depth		17 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		1	11	23			
	Inspected By (Sign) & Date		Ravi 1/11/23					

Reviewed by (Engineer-CNC) Satish 1/11/23

Manager-QA

Scanned with CamScanner