6435

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.		10675/	38/55
2	Machined By		V.T.L. M/c Shop	Dg No: L.S.O. 407 Rev: 00
3	Pallet Die No.		11373 (4.0) HH	
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710 HH Step OD: 698.8 HH	Step length: 20 HH Tapper: 12°
6	Inside Diameter	Drg. No.	600.12 HH	
7	Width of Pellet Die	Drg. No.	222 HH	
8	Grooves as per Drawing	Drg. No.	12x8x7 HH / 12x8x7 HH	
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 HH	
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: 20.4 HH Tapping Depth: 18.8 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 16/11/23	
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						Ravi 32
2	External Relief Dia	4.5 HH	Outside (23-31)		Inner			
3	External Relief Depth		01 HH		17 HH			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		16	11	23			
	Inspected By (Sign) & Date		Ravi 16/11/23					

Satya 16/11/23
Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner