6428

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.		10666	40/50
2	Machined By		V.T.L m/c Shop	Dy No: L.S.D-21 Rev: 00
3	Pallet Die No.		11348 (4.0) HH	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 HH, Step OD: 499 HH	Tapper: 12°
6	Inside Diameter	Drg. No.	420.12 HH,	Step length: 17 HH
7	Width of Pellet Die	Drg. No.	158 HH	
8	Grooves as per Drawing	Drg. No.	12x8x3 HH / 12x8x3 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: 8 Both Side
12	Tapping PCD		454 HH	
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 - 21.4 HH Tapping Depth: 19.8	
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 20
2	External Relief Dia	4.5 HH	Outside (2-2)		Inner			
3	External Relief Depth		14 HH		10 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					

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

Manager-QA

Scanned with CamScanner