6577

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.		10796	36/50
2	Machined By		V.T.L. n/c Shop	Drg No. L.S.D. 450
3	Pallet Die No.		11529 (3.0) mm	Rev 00
4	Die Category	Drg. No.	JEW	
5	Out Side Diameter	Drg. No.	730 mm, Step OD = 743.3 mm	Tapper 10°
6	Inside Diameter	Drg. No.	630.12 mm	Step length 23 mm
7	Width of Pellet Die	Drg. No.	290 mm	Undercut = 6.7 mm
8	Grooves as per Drawing	Drg. No.	15×8×5 mm / 15×8×5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Hole = 16 Both Side
12	Tapping PCD		685 mm	
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 = 21.3 mm	Tapping Depth = 19 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 9/12/23	
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 — 2 Hole Colored	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Rev = 52
2	External Relief Dia	3.5 mm	outside (3.3)		Inner			
3	External Relief Depth		20 mm		14 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		9	12	23			
	Inspected By (Sign) & Date		Ravi 9/12/23					

Satya 9/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner