6623

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.		10903	36/55
2	Machined By		V.T.L. H/C Shop	Dy No. 13.0.457 Rev 00
3	Pallet Die No.		10315 (3.5) HH	
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	770 HH, Step OD. 800 HH Step length 38 HH 36.3 HH	
6	Inside Diameter	Drg. No.	660.12 HH	
7	Width of Pellet Die	Drg. No.	316.3 HH	Undercut = 15 HH
8	Grooves as per Drawing	Drg. No.	2 x 8 x 7.5 HH / 2 x 8 x 7.5 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		H/C Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		725 HH	
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth = 36.2 HH Tapping Depth = 24 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 18/12/23	
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.	

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

1	Counter Sinking Depth & Finish	Ok							Rev = 51
2	External Relief Dia	4.1 HH	Outside (3-3)			Inner			
3	External Relief Depth		22 HH			19 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		18	12	23				
	Inspected By (Sign) & Date		Ravi 18/12/23						

Satyam 18/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner