6642

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
Inprocess Inspection (Pellet Dies)	Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10950	38/50
2	Machined By		V.T.L M/c. Shop	Drg No. LEC-9980
3	Pallet Die No.		11069 (3.0) HH	Rev-00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 HH, Step OD, Tapper 12°	
6	Inside Diameter	Drg. No.	520.12 HH	Step length 18 HH
7	Width of Pellet Die	Drg. No.	222 HH	
8	Grooves as per Drawing	Drg. No.	13x8x5 HH / 13x8x5 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		565 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 21.3 HH	Tapping Depth 19 HH
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Rao 20/12/23	
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						Rao 38
2	External Relief Dia	3.5 HH	Outside (3-3)		Inner			
3	External Relief Depth		18 HH		12 HH			
4	Inspection Done Before Hardening By (Name)		Rao					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		20	12	23			
	Inspected By (Sign) & Date		Rao 20/12/23					

Sotyr 20/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner