6643

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.		10913	40/47
2	Machined By		V.T.L. M/c Shop	Dg No. LEC/5431 Rev. 00
3	Pallet Die No.		11955 (3.0) MM	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	614 MM, Step OD = 612 MM, Step length 19.5	
6	Inside Diameter	Drg. No.	52.12 MM (Bore = 52.14 MM)	
7	Width of Pellet Die	Drg. No.	22.2 MM	
8	Grooves as per Drawing	Drg. No.	13x8x5 MM / 13x8x5 MM	
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 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 = 21.2 MM Tapping Depth = 19 MM	
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						Rad = 38
2	External Relief Dia	3.5 MM	Outside (3-3)		Inner			
3	External Relief Depth		13 MM		7 MM			
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					

20/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner