6647

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.		10955	38/38/45
2	Machined By		V.T.L M/c Shop	Dy No. LSD-296
3	Pallet Die No.		8745 (3.5) MM	Rev. 00
4	Die Category	Drg. No.	M. Tombo	
5	Out Side Diameter	Drg. No.	690 MM, Step OD = 702.8 MM	
6	Inside Diameter	Drg. No.	600.12 MM	Tapper = 4°
7	Width of Pellet Die	Drg. No.	250 MM	Step length = 23.5
8	Grooves as per Drawing	Drg. No.	24×5×9 MM / 24×5×8.9 MM	Under cut = 6.4 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		655 MM	
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 25.6 MM Tapping Depth = 23.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 25/12/23	
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						Raw = 37
2	External Relief Dia	4.0 MM / 4.5 MM	4.5 MM All Lines		5.0 MM All Lines			
3	External Relief Depth		13 MM		7 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		25	12	23			
	Inspected By (Sign) & Date		Ravi 25/12/23					

Satya 25/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner