6686

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.		10937	43/55
2	Machined By		V.T.L. H/C Shop	Drg No. LEC/14951
3	Pallet Die No.		11368 (6-0) HH	Rev: 00
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	630 HH, Step OD: 621.5 HH	Tapper 12°
6	Inside Diameter	Drg. No.	520.12 HH	Step length 21.5
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		H/C Shop	Tapping No. of Hole = 12 Both Side
12	Tapping PCD		565 HH	
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: 81 HH Tapping Depth: 19 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 27/12/23	
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

Counter — ?

1	Counter Sinking Depth & Finish	OK						Ravi 27/12/23
2	External Relief Dia	6-5 HH	Outside (3-3)		Inner			
3	External Relief Depth		19 HH		13 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		27	12	23			
	Inspected By (Sign) & Date		Ravi 27/12/23					

Reviewed by (Engineer-CNC) 27/12/23

Manager-QA

Scanned with CamScanner