6795

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.		11138	40/50
2	Machined By		V.T.L M/c Shop	Drg No = Lark 6355 SRTO
3	Pallet Die No.		11082 (3.5) MM	
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	620 MM, Step OD = 612 MM	Step length 19.4 MM
6	Inside Diameter	Drg. No.	520.12 MM	
7	Width of Pellet Die	Drg. No.	222 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 = 21.3 MM	Tapping Depth = 19 MM
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 17/1/24	
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 = 60°

1	Counter Sinking Depth & Finish	ok						Row = 35
2	External Relief Dia	4.0 MM	Outside (3-3)		Inner			
3	External Relief Depth		17 MM		10 MM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lar Furnace					
6	Material Sent For Hardening On Date		17	1	24			
	Inspected By (Sign) & Date		Ravi 17/1/24					

Satya 17/01/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner