6805

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.		11116	48/48
2	Machined By		V.T.L H/C Shop	Drg No. LB.02-901 Rev. 00
3	Pallet Die No.		11463 (4.0) HH	
4	Die Category	Drg. No.	Both side	
5	Out Side Diameter	Drg. No.	G16 HH Step OD, G12 HH Step length 19.4	
6	Inside Diameter	Drg. No.	52±0.12 HH	
7	Width of Pellet Die	Drg. No.	22 HH	
8	Grooves as per Drawing	Drg. No.	13×8×5 HH / 13×8×5 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 Holes = 12 Both Side
12	Tapping PCD		56.5 HH	
13	Tapping Hole Diameter		M2 = Check by M2 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		Ravi 18/1/24	
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						Rev = 31
2	External Relief Dia	4.5 HH	OD Side (3-31)		Inner			
3	External Relief Depth		4 HH		Mill			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		18	1	24			
	Inspected By (Sign) & Date		Ravi 18/1/24					

Satya 18/01/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner