6804

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.		11052	21/40
2	Machined By		V.T.L. M/c Shop	Drg No. L.S.D.21
3	Pallet Die No.		10941 (2.8) MM	Rev. 01
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 MM Step OD = 499 MM	Tapper 12°
6	Inside Diameter	Drg. No.	420.12 MM	Step length 17 MM
7	Width of Pellet Die	Drg. No.	158 MM	
8	Grooves as per Drawing	Drg. No.	12x8x3 MM / 12x8x3 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 = 8 Both Side
12	Tapping PCD		454 MM	
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19.8 MM Tapping Depth = 17.3 MM	
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						Raw = 26
2	External Relief Dia	3.3 MM	Outside (2-2)		Inner			
3	External Relief Depth		22 MM		19 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		18	1	24			
	Inspected By (Sign) & Date		Ravi 18/1/24					

Satya 18/01/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner