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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

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. 1.3.0.399
3	Pallet Die No.		11734 (24.0) H/c	Row = 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	696 H/c	Step length = 22.5
6	Inside Diameter	Drg. No.	600.12 H/c	Tapper = 4°
7	Width of Pellet Die	Drg. No.	250 H/c	Under cut = 3.5 H/c
8	Grooves as per Drawing	Drg. No.	24x5x9 H/c / 24x5x9 H/c	
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		655 H/c	
13	Tapping Hole Diameter		MIG = Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 25.4 H/c	Tapping Depth = 23 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/1/24

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

Counters = 60°

1	Counter Sinking Depth & Finish	ok							Row = 34
2	External Relief Dia	4.5 H/c	outside (3-3)		Inner				
3	External Relief Depth		4 H/c		Nil				
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	1	24				

Inspected By (Sign) & Date

Ravi 25/1/24

Satya 25/1/24

Reviewed by (Engineer-CNC)

Manager-QA