7046

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.		11296	29/40
2	Machined By		V.T.L M/c Shop	Drg No. 1-EC 7592
3	Pallet Die No.		10969 (3.0) MM	Rev 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 MM, Step OD 491 MM	Step length 17.4
6	Inside Diameter	Drg. No.	420.12 MM	
7	Width of Pellet Die	Drg. No.	158.3 MM	
8	Grooves as per Drawing	Drg. No.	12.1 x 8 x 5 MM / 12 x 8 x 5 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		455 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 22.6 MM Tapping Depth 20.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 2/3/24	
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 - 2 Hole Colused (A)	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter 60° Row 24
2	External Relief Dia	3.5 MM	Outside (2-2)		Inner			
3	External Relief Depth		14 MM		11 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		2	3	24			
	Inspected By (Sign) & Date		Ravi 2/3/24					

Reviewed by (Engineer-CNC) 2/3/24

Manager-QA

Scanned with CamScanner