7078

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.		11359	35/40
2	Machined By		V.T.L. M/c Shop	Drg No. L.S.O. 984 Rev. 00
3	Pallet Die No.		11750 (3.5) HH	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	395 HH, Step OD = 389 HH, Step length = 9.4	
6	Inside Diameter	Drg. No.	315.12 HH	
7	Width of Pellet Die	Drg. No.	145 HH	
8	Grooves as per Drawing	Drg. No.	16 x 6 x 4 HH / 16 x 6 x 4 HH	
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		356 HH	
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Roll	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth = 21.8 HH Tapping Depth = 19 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 8/3/24	
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 — 1 Hole Colored (A)	

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

1	Counter Sinking Depth & Finish	OK							Counter 60° Row : 19
2	External Relief Dia	3.8 HH	Outside (2-2)		Inner				
3	External Relief Depth		8 HH		5 HH				
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		8	3	24				
	Inspected By (Sign) & Date		Ravi 8/3/24						

Reviewed by (Engineer-CNC) Sahil 8/3/24

Manager-QA

Scanned with CamScanner