7098

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.		11408	42/47
2	Machined By		V.T.L M/c Shop	Drg No. L.S.D. 605
3	Pallet Die No.		12079 (3.5) MM	Rest
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	614 MM, Step OD = 614.4 MM	Tapper = 4°
6	Inside Diameter	Drg. No.	520.14 MM	Step length = 20 MM
7	Width of Pellet Die	Drg. No.	222 MM	Udercut = 0.2 MM
8	Grooves as per Drawing	Drg. No.	13x8x5 MM / 13x8x5 MM	3x3 grove After Hard
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 = 12 Both Side
12	Tapping PCD		565 MM	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.7 MM Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 14/3/24	
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	

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

1	Counter Sinking Depth & Finish	ok						Counter = 60° Row = 35
2	External Relief Dia	4.0 MM	Outside (3-3)		Inner			
3	External Relief Depth		12 MM		5 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		14	3	24			
	Inspected By (Sign) & Date		Ravi 14/3/24					

14/3/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner