7295

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.		11670	33/53/66
2	Machined By		V.T.L. N/C Shop	Dwg No. I.D. 609 Rev. 01
3	Pallet Die No.		I.D 40 (6.0) HH	
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 HH, Step OD 693.2 HH	Tapper 8°
6	Inside Diameter	Drg. No.	548.12 HH	Step length 3 HH
7	Width of Pellet Die	Drg. No.	195 HH	Under cut 2.45 HH
8	Grooves as per Drawing	Drg. No.	32.7×8 HH | 32.7×8 HH (4×8) HH	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 9 HH Back Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		619 HH	Tapping No of Holes - 4 Both Side
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 33.5 HH	Tapping Depth, 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 10/4/24	
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 - 30°

1	Counter Sinking Depth & Finish	ok						Rev. 12
2	External Relief Dia	6.5 HH | 7.0 HH	6.5 HH	All Rows	7.0 HH	All Rows		
3	External Relief Depth		33 HH		13 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		10	4	24			
	Inspected By (Sign) & Date		Ravi 1/4/24					

Reviewed by (Engineer-CNC) 10/4/24

Manager-QA

Scanned with CamScanner