7439

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.		11831	53/55
2	Machined By		V.T.L N/C Shop	Drg No. (3.0) = 680
3	Pallet Die No.		12288 (3.8) MM	Rev = 00
4	Die Category	Drg. No.	SEN	
5	Out Side Diameter	Drg. No.	530 MM, Step OD = 491 MM	Step length 7 MM
6	Inside Diameter	Drg. No.	420.12 MM	
7	Width of Pellet Die	Drg. No.	182 MM	
8	Grooves as per Drawing	Drg. No.	10x10x5 MM / 10x10x5 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		N/C Shop	Tapping No. of Holes = 8 Both Side
12	Tapping PCD		455 MM	
13	Tapping Hole Diameter		03/4" = Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19.4 MM	Tapping Depth = 178
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 6/5/24	
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 = 26
2	External Relief Dia	4.3 MM	Outside (2.2)		Inner			
3	External Relief Depth		9 MM		2 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		6	5	24			
	Inspected By (Sign) & Date		Ravi 6/5/24					

Satya 6/5/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner