

7994

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.			
2	Machined By		11946	55/55
3	Pallet Die No.		V.T.L. H/c Shop	Dg. No. 14951
4	Die Category	Drg. No.	11945 (4.5) H/c	Rev. 00
5	Out Side Diameter	Drg. No.	22.29 side	
6	Inside Diameter	Drg. No.	63.04 H/c	Step 00, 6.01.5 H/c, Tapper. 12°
7	Width of Pellet Die	Drg. No.	52.12 H/c	Step length 21.5
8	Grooves as per Drawing	Drg. No.	22.2 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c / 13x3x5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping H/c of Holes 12 Back Side
13	Tapping Hole Diameter		56.5 H/c	
14	Tapping On Second Side	Half pitch of 1st side	H20 = Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.8 H/c	Tapping Depth 18.8
17	Visual Inspection Before Gun Drilling		Yes	
Inspected By (Sign) & Date			Ravi 15/5/24	
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	
<p>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</p>				
1	Counter Sinking Depth & Finish		ok	Counter = 60 Raw = 29
2	External Relief Dia		5.0 H/c	Outside (3-3)
3	External Relief Depth		5 H/c	Inner Mill
4	Inspection Done Before Hardening By (Name)			Ravi
5	Material Sent For Hardening By (Name)			Lark Furnace
6	Material Sent For Hardening On Date		15	5 24
Inspected By (Sign) & Date			Ravi 15/5/24	

Reviewed by (Engineer-CNC)
Satya
 15/5/24

Manager-QA