5876

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.		9735 to 10027	36/50
2	Machined By		V.T.L M/c Shop	Dg No 1.2.1998 Rev 2
3	Pallet Die No.		10018 (3.0) MM	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 MM Step OD, Tapper 12° Step length 19	
6	Inside Diameter	Drg. No.	520.12 MM	
7	Width of Pellet Die	Drg. No.	228 MM	
8	Grooves as per Drawing	Drg. No.	13×8×5 MM / 13×8×5 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	Tapping No of Holes 12 Both Side
11	Tapping Operator		M/c Shop	
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 20.4 MM Tapping Depth 18	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 31/7/23	
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							Ravi 38
2	External Relief Dia	3.5 MM	Out Side (3-3)		Inner				
3	External Relief Depth		20 MM		14 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		31	7	23				
	Inspected By (Sign) & Date		Ravi 31/7/23						

31/7/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner