

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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks	
1	Work Order No.		13649	44/50	
2	Machined By		V.T.L. H/C Shop	6355 Dy. H. Lark 38.10	
3	Pallet Die No.		13661 (4.0) H/C		
4	Die Category	Drg. No.	Extra wide		
5	Out Side Diameter	Drg. No.	620 H/C	Step 00.612 H/C Step length. 18.5	
6	Inside Diameter	Drg. No.	520.12 H/C		
7	Width of Pellet Die	Drg. No.	222 H/C		
8	Grooves as per Drawing	Drg. No.	1348 H/C 5 H/C 1348 H/C 5 H/C		
9	Fitting Sizes on CNC Plate	Drg. No.	ok		
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		H/C Shop	Tapping No. of Hole = 12 Both Side	
12	Tapping PCD		565 H/C		
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 = 3 H/C	Tapping Depth = 18.5 H/C	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 20/12/14		
1	As per programme no.				
2	Gun Drilling Work Completed On				
3	Hole Finish In Gun Drilling	Marked	ok	(A)	
4	Defective Holes (If Any)		No - 1 Hole Closed		
Note : Mark the defective holes/Missed holes with the help of Permanent Marker					
1	Counter Sinking Depth & Finish	ok		Count = 60 Ravi = 31	
2	External Relief Dia	4.5 H/C	outside (3-3)	Inner	
3	External Relief Depth		14 H/C	6 H/C	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Porroce		
6	Material Sent For Hardening On Date		20	12	24
Inspected By (Sign) & Date			Ravi 20/12/14		

Reviewed by (Engineer-CNC)

Manager-QA