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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.		13320	26/47
2	Machined By		V.T.L. N/C Shop	Dry Hole 6.80 1892
3	Pallet Die No.		13702 (3.0) mm	Ream 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	614 mm, 21 step 002 621.5 mm	3 step length 21.5
6	Inside Diameter	Drg. No.	520.2 mm	Tapper 12°
7	Width of Pellet Die	Drg. No.	222 mm	Eden cot. 3.75
8	Grooves as per Drawing	Drg. No.	13x8x5 mm 13x8x5 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 12 Rate Side]
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		N200 Check by N20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 mm	Tapping Depth 18.64
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 7/12/15

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 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.3 mm	All Rows						
3	External Relief Depth		11 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		7	1	25				

Inspected By (Sign) & Date

Ravi 7/12/15

Reviewed by (Engineer-CNC)

Manager-QA