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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.		9618	530/40
2	Machined By		V. T. L N/o Shop	Drg No. L.S.O-8
3	Pallet Die No.		9777 (S.O) N/N	Rev 201
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 N/N Step 00 = 499 N/N	Tapper = 12
6	Inside Diameter	Drg. No.	420.10 N/N	Step length 17 N/N
7	Width of Pellet Die	Drg. No.	158 N/N	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 N/N   12 x 8 x 3 N/N	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/o Shop	
12	Tapping PCD		454 N/N	
13	Tapping Hole Diameter		ø3 1/2" Check by 1/2" Bolt	Tapping No. 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.4 N/N Tapping Depth: 18.8 N/N	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Savi 3/6/13

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								Rev 2 25
2	External Relief Dia	3.5 N/N	outside (2-2)	inner						
3	External Relief Depth		13 N/N	10 N/N						
4	Inspection Done Before Hardening By (Name)			Savi						
5	Material Sent For Hardening By (Name)			Lark Force ce						
6	Material Sent For Hardening On Date		3	6	25					

**Inspected By (Sign) & Date**

Savi 2/6/13

Reviewed by (Engineer-CNC)  5/6/13

Manager-QA