

6024



# 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.		10136	120/120
2	Machined By		V.T.L. M/c Shop	Drg No. 1.3.92 559
3	Pallet Die No.		10467 (3.5) M	Rev. 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	870 M Step 002 743.5 M	Tapped 10
6	Inside Diameter	Drg. No.	630.12 M	
7	Width of Pellet Die	Drg. No.	265 M	
8	Grooves as per Drawing	Drg. No.	15x8x5 M / 15x8x5 M	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No. of holes 16 Both side
12	Tapping PCD		685 M	
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 M Tapping Depth 18.8 M	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 29/7/13

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							
2	External Relief Dia	_____	_____	No Relief					
3	External Relief Depth	_____	_____						
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Kes hoo					
6	Material Sent For Hardening On Date			2	9	23			

Inspected By (Sign) & Date

Ravi 29/7/13

Reviewed by (Engineer-CNC)

Manager-QA