

9281



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.		14251	36/50
2	Machined By		V.T.L. n/c Shop	Dy. No. 12.02.198
3	Pallet Die No.		13559 (4.5) n/c	Peer. co
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	699.8 n/c	Step on 699.8 n/c
6	Inside Diameter	Drg. No.	600.12 n/c	Tapped 12
7	Width of Pellet Die	Drg. No.	222 n/c	Step length 2.2 n/c
8	Grooves as per Drawing	Drg. No.	12x10x7.5 n/c / 12x10x7.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		640 n/c	Tapping No. of holes 12 Both Side
13	Tapping Hole Diameter		M2 x Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 2.3 n/c	Tapping Depth 12.0 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/7/13

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

Counter Bore
Peer. 28

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	5.0 n/c	outside (3-3)		inner		
3	External Relief Depth		19 n/c		14 n/c		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		25	2	25		

Inspected By (Sign) & Date

Ravi 25/7/13

Satish 25/7/13

Reviewed by (Engineer-CNC)

Manager-QA