

9307



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.		14344 ✓	40/50
2	Machined By		V.T.L. n/c Shop	Dy. No. 12.02.612
3	Pallet Die No.		14510 (2.0) n/c	Rev. 2.00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	414.9 n/c, Step OD: 387.8 n/c	Step length 10 n/c
6	Inside Diameter	Drg. No.	315.12 n/c ✓	
7	Width of Pellet Die	Drg. No.	145 n/c ✓	
8	Grooves as per Drawing	Drg. No.	8x8x3 n/c 8x8x3 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		M12: 360 n/c, 03/4" = 355 n/c ✓	[Tapping of holes: 8 Both side]
13	Tapping Hole Diameter		M12 / 03/4" = Check by M12 / 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One side Tapping M12 and 2nd side 03/4"	
15	Tapping Hole Depth		Drill Depth: 20 n/c, Tapping Depth: 18.0 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/07/13

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

Counters: 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	8.5 n/c	outside (2-2)		inner				
3	External Relief Depth		15 n/c		10 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		28	2	25				

Inspected By (Sign) & Date

Ravi 22/07/13

Reviewed by (Engineer-CNC)

Manager-QA