

9320



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.		14335 ✓	46/50 ✓
2	Machined By		V.T.L M/c Shop	Dwg No. L.20.1376
3	Pallet Die No.		14986 (6.0) ✓	Rev. 00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	52mm Step 00.491 ✓	Step length 17.5 ✓
6	Inside Diameter	Drg. No.	42.12 mm ✓	
7	Width of Pellet Die	Drg. No.	158 mm ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm 12x8x3 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	[Tapping Holes of Holes. 8 Both Side]
12	Tapping PCD		454 mm ✓	
13	Tapping Hole Diameter		M20, Check by M20 Ball ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.3 mm	Tapping Depth: 18.5 mm ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 11/8/15

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

1	Counter Sinking Depth & Finish	ok							Counter G ^o Rev. 15
2	External Relief Dia	8.5 mm	Outside (2-2)	Inner					
3	External Relief Depth		10 mm	4 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		1	3	25				

Inspected By (Sign) & Date Ravi 11/8/15

Saty
31/3/15
Reviewed by (Engineer-CNC)

Manager-QA