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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14376	39/52
2	Machined By		V. T. L. n/a Shop	Day 4-2 1.8.9-549
3	Pallet Die No.		14127 (3.0) n/a	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	704mm Step 002 693mm	Tabber 12"
6	Inside Diameter	Drg. No.	600.12 mm	Step length 20mm
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 mm / 12x10x7.5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	Tapping Holes
12	Tapping PCD		640 mm	of Holes 12
13	Tapping Hole Diameter		M20 Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 mm Tapping Depth 18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 20/3/12	
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 - 1 Hole Colours	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter 60
2	External Relief Dia	3.5 mm	Outside (3-3)	Rev 2.38
3	External Relief Depth		19 mm	13 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		20 3 25	
Inspected By (Sign) & Date			Ravi 20/3/12	

Reviewed by (Engineer-CNC)

Manager-QA