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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

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14560 ✓	58/66
2	Machined By		N. J. L. H/c Shop	Drill H. 2.32
3	Pallet Die No.		14774(9.0) H/c	Reo 20
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H/c Step 00-393 H/c Tapper 8	
6	Inside Diameter	Drg. No.	548.12 H/c (548.1 H/c)	Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Lead cut - 2.8 H/c
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 H/c 32.7 x 9.1 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Done Side Step]
10	Drilling Area Surface Smoothness		OK	[2 H/c Deep Bottom Side]
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 H/c	[Tapping H/c of holes 2 Bottom Side]
13	Tapping Hole Diameter		H/c 2 Check by H/c 8.11	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.2 H/c Tapping Depth 31.6 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sav: 27/5/05	
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 60
2	External Relief Dia	10.0 H/c	All holes	Top 8
3	External Relief Depth		8 H/c	
4	Inspection Done Before Hardening By (Name)		Sav!	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		27 3 25	
Inspected By (Sign) & Date			Sav: 27/5/05	

Sav: 27/5/05

Re. Reviewed by (Engineer-CNC)

Manager-QA