

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)

9535

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14549	40/55
3	Pallet Die No.		V.T.C. H/c Shop	By H. 12.0.355
4	Die Category	Drg. No.	13605 (4.0) H/c	Rev. 00
5	Out Side Diameter	Drg. No.	38810	
6	Inside Diameter	Drg. No.	630 H/c	Step length 18 H/c
7	Width of Pellet Die	Drg. No.	520.14 H/c	
8	Grooves as per Drawing	Drg. No.	186 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x3 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rawi Jul 25

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 Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.5 H/c	20 Side	Inner					
3	External Relief Depth	19 H/c		15 H/c					
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date

Rawi Jul 25

Reviewed by (Engineer-CNC)

Manager-QA