

9545

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.		14562	33/50
2	Machined By		V. T. L. H/c Shop	100% 100%
3	Pallet Die No.		14455 (3.0) H/c	Rev. 1.00
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	6.20 H/c	Step 002 Tapped 12°
6	Inside Diameter	Drg. No.	5.20 H/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	22.2 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		56.5 H/c	of holes 12
13	Tapping Hole Diameter		H202 Check by H20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/c	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Soni 31/7/13

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

1	Counter Sinking Depth & Finish	OK								Counter Sink
2	External Relief Dia	3.5 H/c	3.5	Inner						3.5
3	External Relief Depth	2.3 H/c	2.3	1.7 H/c						1.7
4	Inspection Done Before Hardening By (Name)									Soni
5	Material Sent For Hardening By (Name)									Lark for name
6	Material Sent For Hardening On Date									24/7/13

Inspected By (Sign) & Date

Soni 31/7/13

Reviewed by (Engineer-CNC)

Manager-QA