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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.		10318	33/53/79
2	Machined By		V.T.L n/c Shop	Drg No. L.S.O. 717
3	Pallet Die No.		10385 (G.O) n/c	Rev=01
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1008 n/c Step 00 = 1003 n/c	Tappes 8°
6	Inside Diameter	Drg. No.	850.1 n/c	Step length 41 n/c
7	Width of Pellet Die	Drg. No.	266 n/c	Undercut 2.44 n/c
8	Grooves as per Drawing	Drg. No.	45x8x10 n/c 45x8x10 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step n/c Deep Back Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		935 n/c	Tapping n/c of holes. 2 Back Side
13	Tapping Hole Diameter		n/c = Check by n/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 42.44 Tapping Depth. 40.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 14/10/13

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 = 30
2	External Relief Dia	6.5 n/c / 7.0 n/c	6.5 n/c All Cines	7.0 n/c All Cines			Rev=16
3	External Relief Depth		46 n/c	98 n/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Forware				
6	Material Sent For Hardening On Date		14	10	23		

Inspected By (Sign) & Date Ravi 14/10/13

Reviewed by Sohu (Engineer-CNC) 14/10/13

Manager-QA