

6308

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.		10430 ✓	10/40
2	Machined By		N.T.L. n/c Shop	Drg. No. L-3.0 905
3	Pallet Die No.		10703 (3.0) H4	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H4, Step 00, 49 H4	Step length 175
6	Inside Diameter	Drg. No.	420.12 H4	
7	Width of Pellet Die	Drg. No.	158 H4 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H4 / 12x8x3 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping dia of hole 12.8 Both Side
12	Tapping PCD		454 H4	
13	Tapping Hole Diameter		12.8 ± 0.02 Check by 12.84 B. t	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19.8 H4	Tapping Depth 17.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/10/13

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								Rev. 24
2	External Relief Dia	3.5 H4	outside (2.2)			Inner				
3	External Relief Depth		5 H4			Nil				
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		23	10	23					

Inspected By (Sign) & Date

Ravi 23/10/13

Sot... 25/10/13

Reviewed by (Engineer-CNC)

Manager-QA