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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10494	40/50/60
2	Machined By		V.T.L n/c Shop	Dwg No. L.S. 2-586
3	Pallet Die No.		9612 (410) n/c	Rev 200
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 n/c	Step on 2 80 n/c
6	Inside Diameter	Drg. No.	660 n/c	Tabber 10°
7	Width of Pellet Die	Drg. No.	290 n/c	Step long for 30 n/c
8	Grooves as per Drawing	Drg. No.	27 x 8 = 7.5 n/c	Under cut 2 11 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes 12 Both Side
12	Tapping PCD		724 n/c	
13	Tapping Hole Diameter		M22 - Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 29.0 n/c	Tapping Depth 27.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sanjeev 24/10/13

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				
2	External Relief Dia	4.5 n/c 5.0 n/c	4.5 n/c All Lines	5.0 n/c All Lines		
3	External Relief Depth	/	20 n/c	10 n/c		
4	Inspection Done Before Hardening By (Name)		Sanjeev			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		24	10	23	

Inspected By (Sign) & Date

Sanjeev 24/10/13

Reviewed by (Engineer-CNC)
25/10/13

Manager-QA