

6365



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.		10572 ✓	33/50
2	Machined By		V.T.L. n/c Shop	Drg. No. L.E.C. 9980
3	Pallet Die No.		10848 (2.0) ✓	Rev. 2.00 ✓
4	Die Category	Drg. No.	2nd size	
5	Out Side Diameter	Drg. No.	620mm, Step 00 = Tapp. 12" Step 12" ✓	
6	Inside Diameter	Drg. No.	520.12mm ✓	
7	Width of Pellet Die	Drg. No.	222mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm ✓	
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		565mm ✓	
13	Tapping Hole Diameter		n/c Check by H22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm Tapping Depth 18.3mm ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi shilpa

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 - 2 Hole Closed (A)

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

1	Counter Sinking Depth & Finish	ok						Rev: 38
2	External Relief Dia	3.5mm	outside (3.3)		Inner			
3	External Relief Depth		23mm		17mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date							2 11 23

Inspected By (Sign) & Date

Ravi shilpa

Reviewed by (Engineer-CNC)

Manager-QA