

6369



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.		10467	26/36/55
2	Machined By		V.T.L n/c Shop	Drg No. L.S.D. 340
3	Pallet Die No.		11116 (G.O) n/c	Rev. 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	690 n/c, Step OD = 688 n/c	Step length 34.5
6	Inside Diameter	Drg. No.	580.12 n/c	
7	Width of Pellet Die	Drg. No.	266 n/c	
8	Grooves as per Drawing	Drg. No.	28.5 x 6 x 12 n/c 28.5 x 6 x 12 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		630 n/c	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 26.5 n/c	Tapping Depth = 24.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 2/11/13

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. 2.25
2	External Relief Dia	6.5 n/c / 7.0 n/c	6.5 n/c All Lines	7.0 n/c All Lines					
3	External Relief Depth	/ /	29 n/c	19 n/c					
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 2/11/13						

Reviewed by (Engineer-CNC) Manager-QA