
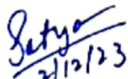


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		Lark Engineering Co. (India) ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (Haryana)		Form No.	CNC/QA/FM/02
				Rev. No.	01
Inprocess Inspection (Pellet Dies)				Rev. Date	31.07.2013
S. No.	Check Parameter	Specification	Observations	Remarks	
1	Work order no.		10796	36/50	
2	Machined By		V.T.L N/C Shop	Dy. No. 13.0 450	
3	Pellet Die No.		10789 (3.0) H/H	Reorder	
4	Die category	Drg. No.	T&D		
5	Outside diameter	Drg. No.	730 H/H, Step 002	743 H/H Step length 33 H/H	
6	Inside Diameter	Drg. No.	630.12 H/H	Tappers 10	
7	Width Of Pellet Die	Drg. No.	290 H/H	Wden cot = 6.7 H/H	
8	Grooves As Per Drawing	Drg. No.	15x8x5 H/H / 15x8x5 H/H		
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 16 Both Side	
12	Tapping PCD		685 H/H		
13	Tapping Hole Diameter		M20, Check by M20 Bolt		
14	Tapping On Second Side	Half pitch of 1st side	ok		
15	Tapping Hole Depth		Drill Depth 20.4 H/H	Tapping Depth 18.8 H/H	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 21/12/13		
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		Row = 52	
2	External Relief Dia.	3.5 H/H	outside 2.33	inner	
3	External Relief Depth		20 H/H	14 H/H	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Furnace		
6	Material Sent For Hardening On Date		21/12/13		
Inspected By (Sign) & Date			Ravi 21/12/13		


 21/12/13
 Reviewed by (Engineer (CNC))

Manager-QA