


6561

	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

S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10813	30/45
2	Machined By		V.T.L. H/O Shop	Qty. 1000
3	Pellet Die No.		10005 (3.0) H/O	Rev. 00
4	Die category	Drg. No.	Outside	
5	Outside diameter	Drg. No.	610 H/O / Step 002 612 H/O	Step length 20 H/O
6	Inside Diameter	Drg. No.	520.12 H/O	Under cut 1 H/O
7	Width Of Pellet Die	Drg. No.	222 H/O	
8	Grooves As Per Drawing	Drg. No.	13x8x5 H/O / 13x8x5 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	Tapping H/O of Holes 12 Botu Side
12	Tapping PCD		564.9 H/O / 565 H/O	
13	Tapping Hole Diameter		H/O - Check by H/O Botu	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/O	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 6/12/13	

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		Rev. 38
2	External Relief Dia.	3.5 H/O	outside (3-3)	Inner
3	External Relief Depth		18 H/O	15 H/O
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		6/12/13	
Inspected By (Sign) & Date			Ravi 6/12/13	


 Reviewed by (Engineer (CNC))

Manager-QA