

6669



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.		10688	28/03/10
2	Machined By		V.T.L. H/c Shop	Dy. No. 130, 389
3	Pallet Die No.		11174 (6.0) H/c	Rec. No.
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	660 H/c, Step: 00, 603 H/c	Tapping 12
6	Inside Diameter	Drg. No.	52.12 H/c	Step length, 18 H/c
7	Width of Pellet Die	Drg. No.	186 H/c	
8	Grooves as per Drawing	Drg. No.	10x10x7 H/c / 10x10x7 H/c	Face side step 1st Deep Both side
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No of holes, 12
12	Tapping PCD		565 H/c / 564.9 H/c	Both side
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 21.2 H/c Tapping Depth: 19 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/12/13

1	As per programme no.			2 Slot
2	Gun Drilling Work Completed On			25 H/c width
3	Hole Finish In Gun Drilling	Marked	ok	6 H/c Deep Both side
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						Rep: 19	
2	External Relief Dia	6.5 H/c / 7.0 H/c	6.5 H/c All Lines	7.0 H/c All Lines					
3	External Relief Depth		48 H/c	38 H/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		28	12	23				

Inspected By (Sign) & Date

Ravi 22/12/13

Reviewed by (Engineer-CNC)

Manager-QA