

9649



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.		10960	35/50
2	Machined By		V.T.L. H/c Shop	Dy. No. 1.3.02/93
3	Pallet Die No.		9979 (4.0) H/c	Reason
4	Die Category	Drg. No.	H-7umbo	
5	Out Side Diameter	Drg. No.	700 H/c Step OD = 692.8 H/c	Tapper 12°
6	Inside Diameter	Drg. No.	600.12 H/c	Step length 20
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 H/c / 12x10x7.5 H/c	
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 Both Side
12	Tapping PCD		640 H/c	
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/c	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 25/12/13

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							Rep = 31
2	External Relief Dia	4.5 H/c	outside (3-3)		Inner				
3	External Relief Depth		19 H/c		15 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		25	12	25				

Inspected By (Sign) & Date

Ravi 25/12/13

Reviewed by (Engineer-CNC)

Manager-QA