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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10967	35/50/66
2	Machined By		V.T.L. n/c Shop	By No. 1.3.0.609
3	Pallet Die No.		11180 (G.2) n/c	Rev: 01
4	Die Category	Drg. No.	M. Tomba	
5	Out Side Diameter	Drg. No.	680.69 n/c Step 002 692.8 n/c	Tappet 3°
6	Inside Diameter	Drg. No.	548.14 n/c	Step length 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32+7+8 n/c 32+7+8 n/c (n/c)	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	Gun Drill Back Side
11	Tapping Operator		n/c Shop	Tapping No
12	Tapping PCD		619 n/c	of holes 4
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 34.4 n/c	Tapping Depth 32 n/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	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

Counter 2 30°

1	Counter Sinking Depth & Finish	ok							
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		31 n/c	16 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		22	12	23				

Inspected By (Sign) & Date

Ravi 22/12/13

Reviewed by (Engineer-CNC)

Manager-QA