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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.		10993	30/50
2	Machined By		N.T.L. H/c Shop	Dry Hole 1.8.09980
3	Pallet Die No.		11079 (3.0) H/c	Rev 2.00
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	6.20 H/c	Step 002 Tapper 12° Step length 18.5
6	Inside Diameter	Drg. No.	5.20 1.2 H/c	
7	Width of Pellet Die	Drg. No.	2.2 2 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping dia of holes 12 Back Side
12	Tapping PCD		5.65 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 20.3 H/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/12/13

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 60°

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	3.5 H/c	outside (2-3)	Inner		
3	External Relief Depth		2.3 H/c	2.0 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		98	12	93	

Inspected By (Sign) & Date

Ravi 28/12/13

28/12/13

Reviewed by (Engineer-CNC)

Manager-QA