

5772

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.		9862	34/40
2	Machined By		V.T.L. H/c Shop	Drg No. Lark 2199
3	Pallet Die No.		10325 (2.8)MM	
4	Die Category	Drg. No.	SEN	
5	Out Side Diameter	Drg. No.	500MM	Step length = 17.4
6	Inside Diameter	Drg. No.	420.12MM	
7	Width of Pellet Die	Drg. No.	182MM	
8	Grooves as per Drawing	Drg. No.	12-8-3MM / 12-8-3MM	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/c Shop	Tapping No. of Holes = 8 Both Side
12	Tapping PCD		454MM	
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 = 18.5MM	Tapping Depth = 16.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Pass: 27/23

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							Row = 31
2	External Relief Dia	2.3MM	outside (2-2)		inner				
3	External Relief Depth		12MM		6MM				
4	Inspection Done Before Hardening By (Name)								Pass
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		8	7	23				

Inspected By (Sign) & Date

Pass: 27/23

Reviewed by (Engineer-CNC)

Manager-QA