

6916



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.		11179	83/55
2	Machined By		VIT. L N/A Shop	Drg No. 19.02.130
3	Pallet Die No.		11639(4.0)M	Rev. 2005
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	708.5M, Step 002 698M, Step length 9.4	
6	Inside Diameter	Drg. No.	600.14M	
7	Width of Pellet Die	Drg. No.	222M	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7M / 12.5 x 8 x 7M	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/A Shop	
12	Tapping PCD		645M	Tapping No of Holes: 12 Botu Side
13	Tapping Hole Diameter		M20 - Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 23.1M Tapping Depth: 20.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sasi 6/2/14

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: 600
Row: 32

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	4.5M	Outside (3-3)	Inner		
3	External Relief Depth		31M	27M		
4	Inspection Done Before Hardening By (Name)		Sasi			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		6	2	24	

Inspected By (Sign) & Date

Sasi 6/2/14

Reviewed by (Engineer-CNC)
Sasi 6/2/14

Manager-QA