

6963-7876



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.		11073	45/50
2	Machined By		V.T.L. H/c Shop	Drg No. 1.5.0. 453
3	Pallet Die No.		11058 (4.0) H/c	Rev. 00
4	Die Category	Drg. No.	SRD	
5	Out Side Diameter	Drg. No.	520.1 H/c Step 002 491.1 H/c	Step length 13.4
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	173 H/c	
8	Grooves as per Drawing	Drg. No.	10x8.5x5 H/c / 10x8.5x5 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 8 Both Side
12	Tapping PCD		455 H/c	
13	Tapping Hole Diameter		034' 2 Check by 034' Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.3 H/c Tapping Depth 19 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 15/8/94*

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					Counter = 60° Rev. 24
2	External Relief Dia	4.5 H/c	Outside (2.2)	Inner			
3	External Relief Depth		13 H/c	5 H/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark For hard				
6	Material Sent For Hardening On Date		15	2	24		
Inspected By (Sign) & Date		<i>Ravi 15/8/94</i>					

Satyam
15/8/94
Reviewed by (Engineer-CNC)

Manager-QA