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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
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11326	36/50
3	Pallet Die No.		V.T.L. H/c Shop	Dr. No. 1.8.0.450
4	Die Category	Drg. No.	11524 (3.0) H/c	Rev. No.
5	Out Side Diameter	Drg. No.	742	
6	Inside Diameter	Drg. No.	730.1 730.1 H/c Step 002 743.4 H/c	
7	Width of Pellet Die	Drg. No.	630.12 H/c	Tapper 10°
8	Grooves as per Drawing	Drg. No.	290 H/c	Step length 28 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	1528 x 15 H/c / 1548 x 5 H/c	Under cut 6.7 H/c
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		685 H/c	Tapping H/c of holes = 16
13	Tapping Hole Diameter		H20 Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.2 H/c	Tapping Depth 18.8 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 19/8/14

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 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	3.5 H/c	Outside (3-3)		Inner					
3	External Relief Depth		20 H/c		14 H/c					

4	Inspection Done Before Hardening By (Name)		<u>Ravi</u>							
5	Material Sent For Hardening By (Name)		<u>Lark Furnace</u>							
6	Material Sent For Hardening On Date		19	8	14					

Inspected By (Sign) & Date Ravi 19/8/14

Reviewed by (Engineer-CNC)

Manager-QA