

5790



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.		9868	40/40
2	Machined By		V.T.L. n/c Shop	Drg nos look 9109
3	Pallet Die No.		10360 (3.0) n/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4mm n/c Step 002 395mm	Step length 14.5
6	Inside Diameter	Drg. No.	32.12mm	
7	Width of Pellet Die	Drg. No.	142mm	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 mm / 15.5 x 7 x 2 mm	
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		355mm	
13	Tapping Hole Diameter		M16 Check by M16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 26mm Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 12/7/13

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 - 2 hole Colused (A)

Note : Mark the defective holes/missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK							Ravi 20
2	External Relief Dia	3.3mm	Outside (2-2)	Inner					
3	External Relief Depth		4mm	Nil					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Furnace					
6	Material Sent For Hardening On Date		12	7	23				

Inspected By (Sign) & Date

Ravi 12/7/13

Reviewed by (Engineer-CNC)
12/7/13

Manager-QA