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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.		11270,	43/50
2	Machined By		V.T.L. H/c Shop	Dy. No. = Lark 8855
3	Pallet Die No.		11682 (4.5) H/c	
4	Die Category	Drg. No.	@ Extra-wide	
5	Out Side Diameter	Drg. No.	6002 H/c, Step OD: 618.2 H/c	Step length: 19.4
6	Inside Diameter	Drg. No.	520.12 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 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: 12 Both Side
12	Tapping PCD		565 H/c	
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: 21.4 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 20/8/14

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: 600
Len: 29

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	5.0 H/c	Outside (3-3)		Inner		
3	External Relief Depth		12 H/c		7 H/c		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Furnace		
6	Material Sent For Hardening On Date		20	2	24		

Inspected By (Sign) & Date

Ravi 20/8/14

20/8/14

Reviewed by (Engineer-CNC)

Manager-QA