

6976



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.		11316	38/50
2	Machined By		V.T.L n/c Shop	Dy. No. 1.50-876
3	Pallet Die No.		11397 (4.3) n/c	Recd. of
4	Die Category	Drg. No.	38810	(A)
5	Out Side Diameter	Drg. No.	619.9 n/c / Step 00. 622.1 n/c / 622.5 n/c	
6	Inside Diameter	Drg. No.	520.12 n/c	Tappers 12
7	Width of Pellet Die	Drg. No.	186 n/c	Step length 20 n/c
8	Grooves as per Drawing	Drg. No.	13x8x3 n/c 13x8x3 n/c	Under cut 1. n/c / 1.35
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 12 Both side
12	Tapping PCD		565 n/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 Repts. 21.4 n/c Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 20/7/14

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. G

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.8 n/c	outside (3.3)		Inner				
3	External Relief Depth		16 n/c		18 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Roxace				
6	Material Sent For Hardening On Date			20	2	24			

Inspected By (Sign) & Date

Ravi 20/7/14

Reviewed by (Engineer-CNC)
S. S. 20/7/14

Manager-QA