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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.		11263	35/40
2	Machined By		V.T.L n/c Shop	Drg No. 21.2.02 865
3	Pallet Die No.		11555(4.5) n/c	Rev 2.00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	39.0 n/c	Step 00.2 383 n/c
6	Inside Diameter	Drg. No.	31.012 n/c	Step length 11.4
7	Width of Pellet Die	Drg. No.	134.9 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c	11.9 x 2x3 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Holes of 4 holes on Both Side
12	Tapping PCD		350 n/c	
13	Tapping Hole Diameter		023/4" = Check by 023/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 91 n/c	Tapping Depth = 18.8 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/7/13

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

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

1	Counter Sinking Depth & Finish	ok					Counter = 6.0 Rev 2.15
2	External Relief Dia	5.0 n/c	outside (2-3)		Inner		
3	External Relief Depth		9 n/c		5 n/c		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Porrace
6	Material Sent For Hardening On Date		21	2	24		

Inspected By (Sign) & Date

Ravi 21/7/13

21/7/13

Reviewed by (Engineer-CNC)

Manager-QA