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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11936	40/50
2	Machined By		V. T. C n/c Shop	Drg No. L.E.C. 1078
3	Pallet Die No.		8893 (4.0) n/c	Row 200
4	Die Category	Drg. No.	M J E D	
5	Out Side Diameter	Drg. No.	700 n/c Step 002 708 n/c	Tapper: 12
6	Inside Diameter	Drg. No.	600.12 n/c	Step length: 24 n/c
7	Width of Pellet Die	Drg. No.	265 n/c	Under cut: 1 n/c
8	Grooves as per Drawing	Drg. No.	15x8x7 n/c / 15x8x7 n/c	
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		640 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 Depth: 21.3 n/c Tapping Depth: 18.2	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/7/14

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 - 1 Hole Closed	

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

Counter: 600 Row 239

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 n/c	Outside (2-3)		Inner				
3	External Relief Depth		14 n/c		10 n/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		22	2	24				

Inspected By (Sign) & Date

Ravi 22/7/14

Reviewed by (Engineer-CNC)

Manager-QA