

6979



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.		11283	35/40
2	Machined By		V.T.L. n/c Shop	Drg No. 1.8.0.865
3	Pallet Die No.		11759 (4.5) n/c	Rev 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	390 n/c Step 002-383 n/c	Step length 11.5
6	Inside Diameter	Drg. No.	310.12 n/c	
7	Width of Pellet Die	Drg. No.	135 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c / 12x8x3 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 = 8 Both Side
12	Tapping PCD		350 n/c	
13	Tapping Hole Diameter		Ø3/4" Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21 n/c Tapping Depth 19 n/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 = 60
Rev = 15

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	5.0 n/c	Outside (2-2)	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 Furnace				
6	Material Sent For Hardening On Date		20	2	24		

Inspected By (Sign) & Date

Ravi 20/8/14

Reviewed by (Engineer-CNC)

Manager-QA