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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.		11416	24/50
2	Machined By		V.T.L. n/c Shop	Drill No. 12.0 245
3	Pallet Die No.		11220 (5.0) H4	Rev: 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 H4 Step 002 693 H4	Tapper, 12°
6	Inside Diameter	Drg. No.	60012 H4	Step length 20 H4
7	Width of Pellet Die	Drg. No.	222 H4	
8	Grooves as per Drawing	Drg. No.	14x8x7 H4	
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 H4	
13	Tapping Hole Diameter		H2.2 Check by H20 B.1	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 22.8 H4	Tapping Depth, 22.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 8/3/14

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	5.5 H4	Outside (3-3)		Inner				
3	External Relief Depth		21 H4		16 H4				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark For nose				
6	Material Sent For Hardening On Date		8	3	24				

Inspected By (Sign) & Date

Ravi 8/3/14

Reviewed by (Engineer-CNC)
8/3/14

Manager-QA