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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.		11339	87155
2	Machined By		V.T.L. n/c Shop	Dr. H. S. 202594
3	Pallet Die No.		12290 (4.5) n/c	Rev. 200
4	Die Category	Drg. No.	3810	
5	Out Side Diameter	Drg. No.	530 n/c 3 step 00 - 491 n/c	Step length 2.4
6	Inside Diameter	Drg. No.	420.12 n/c	Bore = 419.8 n/c
7	Width of Pellet Die	Drg. No.	182 n/c	
8	Grooves as per Drawing	Drg. No.	10x8x3 n/c	10x8x3 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 Bore side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		034" - Check by 034" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19 n/c	Tapping Depth 7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 31/07/14

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								Counter Sink
2	External Relief Dia	5.5 n/c	Outside 2.25		Inner					
3	External Relief Depth		3.2 n/c		2.8 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			8	4	24				

Inspected By (Sign) & Date Ravi 31/07/14

Reviewed by (Engineer-CNC) Satish 31/7/14

Manager-QA