

7287



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.		11703	33/50
2	Machined By		N.T.L. H/c Shop	Dy. H/c 1st 99%
3	Pallet Die No.		11965 (3.0) H/c	Revised
4	Die Category	Drg. No.	Extenside	
5	Out Side Diameter	Drg. No.	6.20 H/c	Step 00 = Tapper = 12° Step length 18
6	Inside Diameter	Drg. No.	5.20.12 H/c	
7	Width of Pellet Die	Drg. No.	9.22 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	13x8x5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping at of H/c 1st Bottom Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H/c Check by H/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 H/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi Gulati

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 - 2 holes observed

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.3 H/c	outside 3-3f	inner 1.7 H/c					
3	External Relief Depth		2.3 H/c						
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		9	4	24				

Inspected By (Sign) & Date Ravi Gulati

Jatin
01/1/14
(Engineer-CNC)

Manager-QA