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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.		9683	29/5 29/5
2	Machined By		N.T.L. n/c Shop	Dy No. 8972 8972 Pinde fitting size Dy No. L.S.D. 845 Revised
3	Pallet Die No.		9838 (3.0) n/c	
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	700 n/c Shop 002 692 n/c	Step length 19.5
6	Inside Diameter	Drg. No.	600.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	15x8 = 7 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		N25 Check by N25 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 29/7/13

1	As per programme no.		ok
2	Gun Drilling Work Completed On		ok
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							Ravi 29
2	External Relief Dia	3.3 n/c	Outside (3-3)		Inner				
3	External Relief Depth		2.4 n/c		2.1 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		29	7	25				

Inspected By (Sign) & Date

Ravi 29/7/13

Reviewed by (Engineer-CNC)

Manager-QA