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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14163	32/48/90
2	Machined By		V. T. L. n/c Shop	Dr. H. L. S. 28
3	Pallet Die No.		14758 (G.O) n/c	Rev. 2.00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	780 n/c, Step 00, 703 n/c	Tapping 4"
6	Inside Diameter	Drg. No.	600-12 n/c	Step length 28 n/c
7	Width of Pellet Die	Drg. No.	221 n/c	
8	Grooves as per Drawing	Drg. No.	57x6x10 n/c 57x6x10 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
12	Tapping PCD		655 n/c	Both Side
13	Tapping Hole Diameter		H16, Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 24.2 n/c	Tapping Depth 22.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 29/8/15	
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	6.5 n/c 7.0 n/c	6.5 n/c A1 Rows 2 58 n/c	Row 2 11
3	External Relief Depth		7.0 n/c A1 Rows 2 42 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Pername	
6	Material Sent For Hardening On Date		29	3 25
Inspected By (Sign) & Date			Ravi 29/8/15	

Reviewed by (Engineer-CNC)

Manager-QA