

9642

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.		14739	42142
2	Machined By		V.T.L. H/O Shop	Dy. 1.0.13.03
3	Pallet Die No.		14636(4.0) H/O	Rev. 1.0.13.03
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	604 H/O Step 00.618.9 H/O	Tapping
6	Inside Diameter	Drg. No.	520.12 H/O	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 H/O	Undercut 7.5 H/O
8	Grooves as per Drawing	Drg. No.	14x8x5 H/O / 14x8x5 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	Tapping H/O
12	Tapping PCD		565 H/O	of holes 12
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/O Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 17/7/13

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

Counter 60

1	Counter Sinking Depth & Finish	OK							Ravi 17/7/13
2	External Relief Dia	4.5 H/O	Outside 23-25		Inner				
3	External Relief Depth		5 H/O		Nil				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		17	4	25				

Inspected By (Sign) & Date

Ravi 17/7/13

Reviewed by (Engineer-CNC)

Manager-QA