

5923



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.		9823 9823	30/50/66
2	Machined By		V.T. L N/C Shop	Drg No. L.S.O. 609
3	Pallet Die No.		10581 (6.0) mm	Rev. 01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 Step 002 693 mm	Step length 31 mm
6	Inside Diameter	Drg. No.	548.14 mm	Taper = 8°
7	Width of Pellet Die	Drg. No.	195 mm	Undercut = 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 mm 32 x 7 x 8 mm (4x8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Face Side Step 2 mm]
10	Drilling Area Surface Smoothness		OK	[Deep Both Side]
11	Tapping Operator		N/C Shop	
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		MIS, Check by M16 Bolt	[Tapping No. of Holes = 4]
14	Tapping On Second Side	Half pitch of 1st side	OK	[Both Side]
15	Tapping Hole Depth		Drill Depth: 33 mm Tapping Depth: 31.7	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 9/8/13

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

1	Counter Sinking Depth & Finish	OK							Coaters 30°
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm	All Lines	7.0 mm	All Lines			Ravi 12
3	External Relief Depth			36 mm		16 mm			
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Pornece
6	Material Sent For Hardening On Date								23

Inspected By (Sign) & Date

Ravi 9/8/13

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Reviewed by (Engineer-CNC)

Manager-QA