

5601



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.		9560 to 9696	28/38/68
2	Machined By		V. T. C. n/c Stop	Drg. No. 1.8.0.2.6.0.9
3	Pallet Die No.		10253 (B.O.)	Rec 201
4	Die Category	Drg. No.	H. Jumbo	Groove 4x3
5	Out Side Diameter	Drg. No.	680.6mm	Step 002 693mm
6	Inside Diameter	Drg. No.	548.1mm	Step length 31mm
7	Width of Pellet Die	Drg. No.	195mm	Tapper 8°
8	Grooves as per Drawing	Drg. No.	32x7x8mm	Under cut = 2.5mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side step 2mm
10	Drilling Area Surface Smoothness		OK	Deep Both side
11	Tapping Operator		n/c Stop	Tapping n/c
12	Tapping PCD		619mm	of 4.0.4
13	Tapping Hole Diameter		MIG2 Check by MIG B. It	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 33.4mm	Tapping Depth: 31.7mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw! 31/7/13

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		Nil

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

1	Counter Sinking Depth & Finish	OK					Counter 30°
2	External Relief Dia	6.5mm / 7.3mm	6.5mm All Lines	7.3mm All Lines			Raw 210
3	External Relief Depth		28mm	28mm			
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		3	6	23		

Inspected By (Sign) & Date

Raw! 31/7/13

5/6/13

Reviewed by (Engineer-CNC)

Manager-QA