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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.		13751	33/66
2	Machined By		V. T. L. n/c Shop	Dy No. 130 2609
3	Pallet Die No.		13997 (10.0) n/c	Rev 203
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm / Step 00. 693 mm	Tapper 8°
6	Inside Diameter	Drg. No.	548.12 mm / Bor = 548.3 mm	Step length 31
7	Width of Pellet Die	Drg. No.	195 mm	Under cut = 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm / 32 x 7 x 9.1 mm	(4 x 3) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face side Step 2 mm Deep Both side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		N16	Tapping No. of holes = 2 Both side
14	Tapping On Second Side	Half pitch of 1st side	Check by N16 Bolt ok	
15	Tapping Hole Depth		Drill Depth. 33 mm	Tapping Depth. 31.5 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 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)		No

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

1	Counter Sinking Depth & Finish	ok						Counters 60° Rev. 8
2	External Relief Dia	11.0 mm	All Rows					
3	External Relief Depth		28 mm					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Purchase					
6	Material Sent For Hardening On Date		8	1	25			

Inspected By (Sign) & Date

Ravi 31/7/13

Reviewed by (Engineer-CNC)

Manager-QA