

8996



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.		13871	35/40/66 ✓
2	Machined By		V.T.L H/C Shop	Drg No. L3.D2.609
3	Pallet Die No.		14006 (G.O) H/C	Rev. 03 ✓
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	620.7 H/C Step OD = 693 H/C	Tapper 2° ✓
6	Inside Diameter	Drg. No.	(A) 546.12 H/C 547.6 H/C (Rev = 548.1)	Step long 4.31 H/C
7	Width of Pellet Die	Drg. No.	195 H/C	(A) Under cut = 2.5 H/C
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 H/C 32.7 x 8.7 H/C	(4 x 8) H/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	
10	Drilling Area Surface Smoothness		ok	Face side Step 2 H/C Deep Both side
11	Tapping Operator		H/C Shop	
12	Tapping PCD		619 H/C	
13	Tapping Hole Diameter		H/C = Check by H/C Bolt	Tapping H/C of Holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both side
15	Tapping Hole Depth		Drill Depth = 38.3 H/C	Tapping Depth = 31.5 H/C
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/12/13

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 = 30°

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	6.5 H/C 7.0 H/C	6.5 H/C All Rows =	31 H/C				
3	External Relief Depth	/ /	7.0 H/C All Rows =	26 H/C				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		14	1	25			

Inspected By (Sign) & Date

Ravi 14/12/13

Reviewed by (Engineer-CNC)
Sathy 14/12/13

Manager-QA