

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)

Remarks

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15171	26145
2	Machined By		V/L - MIC Shap	
3	Pallet Die No.		14312 (3-0)	Drg. No. 615-1
4	Die Category	Drg. No.	SSSUD	
5	Out Side Diameter	Drg. No.	610 mm, OD Step-623.8mm	Step length-20
6	Inside Diameter	Drg. No.	520 mm	
7	Width of Pellet Die	Drg. No.	186 mm	Tapping 12"
8	Grooves as per Drawing	Drg. No.	13 X 8 X 3 mm	(Undercut-7mm)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		MIC Shap	(Tapping Holes - 12)
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 Check M20 belt)	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drilling Depth-20.3mm Tapping Depth-18.6	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

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					
2	External Relief Dia	Ø 3.5	outside	1mm			
3	External Relief Depth	22mm (3-3)	19mm				
4	Inspection Done Before Hardening By (Name)		Sanju				
5	Material Sent For Hardening By (Name)		hank				
6	Material Sent For Hardening On Date		11	6	25		

Inspected By (Sign) & Date

Reviewed by (Engineer-CNC)

Manager-QA