

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)

10145

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15140	45/50
2	Machined By		V. T. L. H/C Shop	Drg No. 180-4-3
3	Pallet Die No.		15079 (B.O.)	Rev 20
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520.3 mm	Step 002 491 mm Step length 17
6	Inside Diameter	Drg. No.	420.14 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm / 12 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping of holes B Both side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		23/16" = 29.17 mm by 23/16" R. 1	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Reamer 19 mm Tapping Depth = 17 mm	
16	Perpendicularity of Tapped Hole		YES	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

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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 60

1	Counter Sinking Depth & Finish	OK						Rev 12
2	External Relief Dia	25 mm	outside 22-23	1 mm				
3	External Relief Depth		10 mm	5 mm				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		23	6	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA