



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.			
2	Machined By		15632	55/66
3	Pallet Die No.		V.T.L. H/c Shop	Qty 1-82-32
4	Die Category	Drg. No.	15558(80) H/c	Rev 208
5	Out Side Diameter	Drg. No.	M. Jumbo	692.8mm
6	Inside Diameter	Drg. No.	680.2mm	Step 00. 8°
7	Width of Pellet Die	Drg. No.	546.14mm (Box 2 548.2)	Step length 31mm
8	Grooves as per Drawing	Drg. No.	195mm	Order 2.7mm
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.1mm 32.7 x 9.1mm (4x8)mm	
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		OK	2mm Drill
12	Tapping PCD		H/c Shop	Both Side
13	Tapping Hole Diameter		619mm	Tapping Hole
14	Tapping On Second Side	Half pitch of 1st side	H16 - Check by H16 Bolt	of holes 2
15	Tapping Hole Depth		OK	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.7mm	Tapping Depth 31.2
17	Visual Inspection Before Gun Drilling		Yes	
	Inspected By (Sign) & Date			
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
4	Defective Holes (If Any)		OK	
	Note : Mark the defective holes/Missed holes with the help of Permanent Marker			
1	Counter Sinking Depth & Finish			Counter 30°
2	External Relief Dia		9.0mm	Box 2 10
3	External Relief Depth			
4	Inspection Done Before Hardening By (Name)			
5	Material Sent For Hardening By (Name)			
6	Material Sent For Hardening On Date		28	7 25
	Inspected By (Sign) & Date			

Reviewed by (Engineer-CNC)

Manager-QA