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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.		10958	30/79
2	Machined By		V.T.L. M/c Shop	Dr. No. 1-8-02-217
3	Pallet Die No.		11175 (6.0) M/c	Rev. 01
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1008 M/c Step OD: 1023 M/c	Tapper: 8°
6	Inside Diameter	Drg. No.	850.12 M/c 850.14 M/c	Step length: 41 M/c
7	Width of Pellet Die	Drg. No.	266 M/c	Under cut: 2.6 M/c
8	Grooves as per Drawing	Drg. No.	45x8x10 M/c 45x8x10 M/c (8x10) M/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side 2 M/c Deep Probe Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No. of Holes: 2
12	Tapping PCD		935 M/c	Both Side
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 42.3 M/c	Tapping Depth: 29.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 22/11/14

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

Counters 30°
Row: 16

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	7.3 M/c	All Rows				
3	External Relief Depth		49 M/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		22		24		

Inspected By (Sign) & Date

Ravi 22/11/14

Reviewed by (Engineer-CNC)

Manager-QA