

6910



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.		11165	33/28/66
2	Machined By		V.T.L H/C Shop	Dy. No. 12.02.609
3	Pallet Die No.		11481 (6.0) H/C	Rev. 2.01
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	680.69 H/C Step OD = 692.8	① Tappers 8°
6	Inside Diameter	Drg. No.	548.12 H/C	Step length 3.4 H/C
7	Width of Pellet Die	Drg. No.	195 H/C	Order cut = 2.4 H/C
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/C / 32 x 8 x 8 H/C (4x8)	Face Side Step
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Back Side
10	Drilling Area Surface Smoothness		OK	Deep Back Side
11	Tapping Operator		H/C Shop	Tapping of Holes 4 Back Side
12	Tapping PCD		619 H/C	
13	Tapping Hole Diameter		H16 - Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.4 H/C	Tapping Depth 31.2 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 5/2/14

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

1	Counter Sinking Depth & Finish	OK							Counter = 30°
2	External Relief Dia	6.5 H/C / 7.5 H/C	6.5 H/C All Rows	7.5 H/C All Rows					Rows = 12
3	External Relief Depth		33 H/C	28 H/C					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Porrace						
6	Material Sent For Hardening On Date		5	2	24				

Inspected By (Sign) & Date

Ravi 5/2/14

Sah 5/2/14

Reviewed by (Engineer-CNC)

Manager-QA