

70.10



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11281	98/38/66
2	Machined By		V.T.L. n/c Shop	Dr. No. 1.3.0289
3	Pallet Die No.		11910 (6.0) n/c	Rev. 01
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 n/c	Step 002 692.8 n/c
6	Inside Diameter	Drg. No.	548.12 n/c	Tappers 8°
7	Width of Pellet Die	Drg. No.	195 n/c	Step length 31 n/c
8	Grooves as per Drawing	Drg. No.	32x7x8 n/c	Width 2.5 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	32x7x8 n/c (4x8)	ok
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		n/c Shop	Back Btm Side
12	Tapping PCD		619 n/c	Tapping No. of holes 4
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.4 n/c	Tapping Depth 31.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/7/14

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 n/c	7.3 n/c	6.5 n/c All Rows	7.3 n/c All Rows		Rev 2/2
3	External Relief Depth	/		38 n/c	38 n/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			26	2	24	

Inspected By (Sign) & Date

Ravi 28/7/14

Satish 28/7/14

Reviewed by (Engineer-CNC)

Manager-QA