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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.		9788	55/60
2	Machined By		V.T.L. n/c Shop	Dy No. 1.8.0.584
3	Pallet Die No.		10382	Rev 2.01
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm Step OD, 797.8mm	Step length 25.5
6	Inside Diameter	Drg. No.	660.12mm	Tapper 4°
7	Width of Pellet Die	Drg. No.	323.8mm	Undercut 8.8mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10mm 21.5 x 8 x 10mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping N. of Holes - 12 Both Side
12	Tapping PCD		725mm	
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 - 30.5mm	Tapping Depth - 29.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ins: 22/7/13

1	As per programme no.			2 sl. t 32.1mm width 8mm Deep Both Side
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						Rev=19
2	External Relief Dia	10.5mm	Outside (3-3)		Inner			
3	External Relief Depth	✓	10mm		5mm			
4	Inspection Done Before Hardening By (Name)							Ins:
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		22	7	22			

Inspected By (Sign) & Date

Ins: 22/7/13

Reviewed by (Engineer-CNC)

Manager-QA