



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)

6927

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11035	24/40
2	Machined By		M.T.L.Hlc Shop	Drg. No. 1.3.02839
3	Pallet Die No.		11749 (3.2) H4	Rev 2.00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	395 H4 Step OD. 389 H4 Step length 9.4	
6	Inside Diameter	Drg. No.	315.12 H4	
7	Width of Pellet Die	Drg. No.	145 H4	
8	Grooves as per Drawing	Drg. No.	16x8x3 H4 16x8x3 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		Hlc Shop	Tapping No. of Holes: 8 Back Side
12	Tapping PCD		358 H4	
13	Tapping Hole Diameter		ø3/4" = Check by ASL & Bal	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 21.3 H4 Tapping Depth: 19 H4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/7/14

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

Counter sink

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	2.8 H4	80 Side (2.2)		Inner					
3	External Relief Depth		19 H4		16 H4					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Roxace					
6	Material Sent For Hardening On Date				A	2	24			

Inspected By (Sign) & Date

Ravi 21/7/14

Saty 21/7/14

Reviewed by (Engineer-CNC)

Manager-QA