

7028



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.		11346	40/40
2	Machined By		N.T.L. Shop	Drg No. 3195 310
3	Pallet Die No.		10963 (4.5) H4	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H4 Step OD 491 H4	Step length 17.4
6	Inside Diameter	Drg. No.	420.12 H4	
7	Width of Pellet Die	Drg. No.	158 H4	
8	Grooves as per Drawing	Drg. No.	12x8x3 H4 12x8x3 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No. of holes 8 Both Side
12	Tapping PCD		454 H4	
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 19 H4 Tapping Depth 17 H4	
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

Counter 60

1	Counter Sinking Depth & Finish	OK								28.18
2	External Relief Dia	5.0 H4	Outside 2-25		Inner					
3	External Relief Depth		5 H4		Null					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									Lark Porrace
6	Material Sent For Hardening On Date			28	2	24				

Inspected By (Sign) & Date

Ravi 28/7/14

Reviewed by (Engineer-CNC)
28/7/14

Manager-QA