

	Lark Engineering Co. (India) ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (Haryana)	Form No.	CNC/QA/FM/02
	Inprocess Inspection (Pellet Dies)	Rev. No.	01
		Rev. Date	31.07.2013

S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10725	53/58
2	Machined By		V.T.L. n/c Shop	Digital L.S.C 6986
3	Pellet Die No.		11009 (3.8) n/c	Pen 00 87 88
4	Die category	Drg. No.	Jumbo	
5	Outside diameter	Drg. No.	776 n/c	Step OD = 8 mm
6	Inside Diameter	Drg. No.	660.12 n/c	Step length = 26 mm
7	Width Of Pellet Die	Drg. No.	316 n/c	Wider cut = 12 mm
8	Grooves As Per Drawing	Drg. No.	20 x 8 x 7.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	20 x 8 x 7.5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		78.5 n/c	Tapping No of holes 12 Both Side
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 = 25.4 n/c	Tapping Depth = 3.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 30/11/23*

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 - 1 Hole Closed	

Note: Mark the defective holes/missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok		
2	External Relief Dia.	4.3 mm	Outside (3-3)	Row = 47
3	External Relief Depth		12 mm Inner 5 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		30/11/23	

Inspected By (Sign) & Date *Ravi 30/11/23*

Ravi
30/11/23
Reviewed by (Engineer (CNC))

Manager-QA