

	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.		10777	50/50
2	Machined By		V.T.L. M/C Shop	Dr. No. 1.8.0 = 578
3	Pellet Die No.		11100 (B.5) M/C	Rev. 01
4	Die category	Drg. No.	Outside	
5	Outside diameter	Drg. No.	620 M/C	Step OD = 615.5 M/C
6	Inside Diameter	Drg. No.	530.12 M/C	Tapper = 4
7	Width Of Pellet Die	Drg. No.	322 M/C	Step length = 20 M/C
8	Grooves As Per Drawing	Drg. No.	13x8x5 M/C	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 M/C	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		565 M/C	Tapping No. of holes = 12 Both Side
13	Tapping Hole Diameter		M2 = Check by M2 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.4 M/C	Tapping Depth = 19 M/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 2/12/23*

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	

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

1	Counter Sinking Depth & Finish	ok		Rev = 35
2	External Relief Dia.	4.0 M/C	Outside 23-29	Inner
3	External Relief Depth		4 M/C	Nil
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		2/12/23	

Inspected By (Sign) & Date *Ravi 2/12/23*

Satyam
2/12/23
Reviewed by (Engineer (CNC))

Manager-QA