


6514

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

S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10751	34/47
2	Machined By		V.T.L H/c Shop	Dy. No. L&C 776
3	Pellet Die No.		11098 (3.2) H/c	Rev. 01
4	Die category	Drg. No.	Extra side	
5	Outside diameter	Drg. No.	614 H/c, Step OD, 623.8 H/c	Tapper. 12
6	Inside Diameter	Drg. No.	520.12 H/c	Step length, 18 H/c
7	Width Of Pellet Die	Drg. No.	222 H/c	Under cut = 4.8 H/c
8	Grooves As Per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of Hole. 12 Both Side
12	Tapping PCD		56.5 H/c	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.4 H/c	Tapping Depth 19 H/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

<b>Inspected By (Sign) &amp; Date</b>		Ravi 28/11/23		
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		Rev. 37
2	External Relief Dia.	3.8 H/c	Outside 3.5 / Inner	
3	External Relief Depth		17 H/c / 13 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		28/11/23	
<b>Inspected By (Sign) &amp; Date</b>		Ravi 28/11/23		

Satsa  
28/11/23  
Reviewed by (Engineer (CNC))

Manager-QA