



6321

		Lark Engineering Co. (India)		Form No.	CNC/QA/FM/02
		ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (Haryana)		Rev. No.	01
		Inprocess Inspection (Pellet Dies)		Rev. Date	31.07.2013
S. No.	Check Parameter	Specification	Observations	Remarks	
1	Work order no.		9204 ✓	75/75 ✓	
2	Machined By		V.T.L H/C Shop	Drg No. L.S.02	691
3	Pellet Die No.		11112 (8.0) H/H	Rev 2008	
4	Die category	Drg. No.	S. Jumbo ✓		
5	Outside diameter	Drg. No.	1060.7 H/H Step 002	1041 H/H Tapper 4"	
6	Inside Diameter	Drg. No.	911.1 H/H ✓	Step length = 29 H/H	
7	Width Of Pellet Die	Drg. No.	387.8 H/H		
8	Grooves As Per Drawing	Drg. No.	33x10x10 H/H / 33x10x10 H/H		
9	Fitting Sizes on CNC Plate	Drg. No.	OK		
10	Drilling Area Surface Smoothness		OK		
11	Tapping Operator		H/C Shop	Tapping Holes, 16 Bolt Side	
12	Tapping PCD		975 H/H ✓		
13	Tapping Hole Diameter		M24 = Check by M24 Bolt		
14	Tapping On Second Side	Half pitch of 1st side	OK		
15	Tapping Hole Depth		Drill Depth = 40.4 H/H	Tapping Depth = 38.4	
16	Perpendicularity of Tapped Hole		Yes		
17	Visual Inspection Before Gun Drilling		OK		
Inspected By (Sign) & Date			Ravi 29/11/23		
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		
Note: Mark the defective holes/missed holes with the help of Permanent Marker					
1	Counter Sinking Depth & Finish	OK			Rev 230
2	External Relief Dia.	9.0 H/H	Outside 3.35 / Inner 3.17 / Nil		
3	External Relief Depth				
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Fortrace		
6	Material Sent For Hardening On Date		29/11/23		
Inspected By (Sign) & Date			Ravi 29/11/23		

  
 Reviewed by (Engineer (CNC))

Manager-QA