

	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.		10057	33/40
2	Machined By		V. T. L n/c Shop	Drg No. 1.8.C. 7700
3	Pellet Die No.		10336 (3.0) n/c	Rev. 01
4	Die category	Drg. No.	5910	
5	Outside diameter	Drg. No.	500 n/c, Step OD, 492 n/c	Step length 17 n/c
6	Inside Diameter	Drg. No.	492.12 n/c	
7	Width Of Pellet Die	Drg. No.	182 n/c	
8	Grooves As Per Drawing	Drg. No.	10x9.5 x 5 n/c / 10x9.5x5 n/c	
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		457 n/c	
13	Tapping Hole Diameter		M20 = Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 19 n/c
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		Lev 30
2	External Relief Dia.	3.5 n/c	085-35	Inner
3	External Relief Depth		11 n/c	8 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		29/11/23	

Inspected By (Sign) & Date Ravi 29/11/23

Sotav
29/11/23

Reviewed by (Engineer (CNC))

Manager-QA