


6513

	<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.		9204/	75/75
2	Machined By		V.T.L H/c Shop	Drg No. L.S.O. 691
3	Pellet Die No.		11111 (8.0) H/c	Rev. 00
4	Die category	Drg. No.	S. Jumbo	
5	Outside diameter	Drg. No.	1061.2 H/c, Step 001	1041.5 H/c Tapper 4°
6	Inside Diameter	Drg. No.	911.12 H/c	Step length 29 H/c
7	Width Of Pellet Die	Drg. No.	387.8 H/c	
8	Grooves As Per Drawing	Drg. No.	33x10x10 H/c / 33x10x10 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 holes, 16 Both Side
12	Tapping PCD		975 H/c	
13	Tapping Hole Diameter		H24 - Check by H24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth, 40.5 H/c	Tapping Depth 38.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rasi 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	

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

1	Counter Sinking Depth & Finish	OK		Row = 30
2	External Relief Dia.	9.0 H/c	outside (3-3) 8 H/c	Inner Mill
3	External Relief Depth			
4	Inspection Done Before Hardening By (Name)		Rasi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		28/11/23	
Inspected By (Sign) & Date			Rasi 28/11/23	

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

Manager-QA