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	<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.		10750	
2	Machined By		V.T.L H/C Shop	48/55
3	Pellet Die No.		11032 (4.0) H/C	Qty No. L.S.O. 539
4	Die category	Dr. No.	SSSTO	Rev 200
5	Outside diameter	Dr. No.	630 H/C, Step 002 624 H/C	Step length 20mm
6	Inside Diameter	Dr. No.	590.12 H/C	Tapper, 12°
7	Width Of Pellet Die	Dr. No.	186 H/C	
8	Grooves As Per Drawing	Dr. No.	13x8x3 H/C / 13x8x3 H/C	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of holes, 12 Both Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		M202 Check by M20 R/L	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.8 H/C	Tapping Depth = 19 H/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		Row = 25
2	External Relief Dia.	4.5 H/C	outside (3-3) / Inner	
3	External Relief Depth		15 H/C / 7 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		29/11/23	
Inspected By (Sign) & Date			Ravi 29/11/23	

  
 29/11/23  
 Reviewed by (Engineer (CNC))

Manager-QA