


6528

 Lark Engineering Co. (India) ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (Haryana)		Form No.	CNC/QA/FM/02	
		Rev. No.	01	
Inprocess Inspection (Pellet Dies)		Rev. Date	31.07.2013	
S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10776	48/48
2	Machined By		V.T.L H/C Shop	Qty Nos 1.30.901
3	Pellet Die No.		11099 (4.0) H	Revoo
4	Die category	Drg. No.	Extra wide	
5	Outside diameter	Drg. No.	616 H / Step OD 612 H / Step length 19.5	
6	Inside Diameter	Drg. No.	520.12 H	
7	Width Of Pellet Die	Drg. No.	222 H	
8	Grooves As Per Drawing	Drg. No.	13x8x5 H / 13x8x5 H	
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 = 12 Back Side
12	Tapping PCD		565 H	
13	Tapping Hole Diameter		M2 = Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.4 H / Tapping Depth 19 H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 30/11/23	
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		Ravi 31
2	External Relief Dia.	4.5 H / outside (2-3)	Inner	
3	External Relief Depth	4 H /	mill	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		30/11/23	
Inspected By (Sign) & Date			Ravi 30/11/23	


 30/11/23
 Reviewed by (Engineer (CNC))

Manager-QA