

	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.		10813	35/45
2	Machined By		V.T.L. n/c Shop	1 Drg. No. 1.8C.15430
3	Pellet Die No.		9415 (3.0) n/c	Rev 2.00
4	Die category	Drg. No.	2nd side	
5	Outside diameter	Drg. No.	61mm / Step OD = 61.2mm	Step length = 2mm
6	Inside Diameter	Drg. No.	52.12 mm	Undercuts 1mm
7	Width Of Pellet Die	Drg. No.	22.2 mm	
8	Grooves As Per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping H. of Holes 12 Both Side
12	Tapping PCD		56.5 mm	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 mm	Tapping Depth = 13.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 5/12/23

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 = 38
2	External Relief Dia.	3.5 mm	Outside (2-3) Inner	
3	External Relief Depth		16 mm 10 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		5/12/23	

Inspected By (Sign) & Date Ravi 5/12/23

S. J.
5/12/23
Reviewed by (Engineer (CNC))

Manager-QA