

		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.		10747	45/50	
2	Machined By		V.T. N/C Shop	Dy. No. 18.0.970	
3	Pellet Die No.		11339 (6.0) mm	Rev. No.	
4	Die category	Drg. No.	Senior		
5	Outside diameter	Drg. No.	5.90 mm, Step OD =	4.91 mm Step length 17.5	
6	Inside Diameter	Drg. No.	4.20.12 mm	19 mm	
7	Width Of Pellet Die	Drg. No.	159.5 mm		
8	Grooves As Per Drawing	Drg. No.	13.5 x 8 x 3 mm / 18 x 8 x 3 mm		
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] Bottom Side	
12	Tapping PCD		4.54 mm		
13	Tapping Hole Diameter		0.316" Check by 0.316" Bolt		
14	Tapping On Second Side	Half pitch of 1st side	ok		
15	Tapping Hole Depth		Drill Depth 19 mm	Tapping Depth 17 mm	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Ravi 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 15	
2	External Relief Dia.	6.5 mm	outside	Inner	
3	External Relief Depth	✓	11 mm	5 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		28/11/23		
Inspected By (Sign) & Date			Ravi 28/11/23		


 Reviewed by (Engineer (CNC))

Manager-QA