


6851

	<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.		10755HH	40/50
2	Machined By		V. T. L. H/C Shop	Dy. Mgr. Lark 5570
3	Pellet Die No.		11084 (4.0)HH	
4	Die category	Drg. No.	Extra side	
5	Outside diameter	Drg. No.	62mm Step OD = 61.9mm	Step length = 19.5
6	Inside Diameter	Drg. No.	52.012mm	
7	Width Of Pellet Die	Drg. No.	222mm	
8	Grooves As Per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping H <sub>2</sub> O of holes = 12 Back side
12	Tapping PCD		56.5mm / 56.49mm	
13	Tapping Hole Diameter		H <sub>2</sub> O, Check by H <sub>2</sub> O Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.4mm	Tapping Depth = 19mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	


Inspected By (Sign) & Date Ravi 21/7/23

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		Ravi 31
2	External Relief Dia.	4.5mm	outside (3-3)	Inner
3	External Relief Depth	—	14mm	10mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		21/7/23	

Inspected By (Sign) & Date Ravi 21/7/23

  
Reviewed by (Engineer (CNC))

Manager-QA