
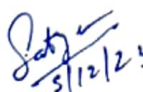


6558

		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.		10732/	42/40	
2	Machined By		Y.T.L. H/c Shop	Dy. No. L.F.C. 15062	
3	Pellet Die No.		10729 (4.5) H/c	Ravi	
4	Die category	Drg. No.	Senior		
5	Outside diameter	Drg. No.	500 H/c	Step OD = 12" - 498.88	
6	Inside Diameter	Drg. No.	420.12 H/c	Step length = 18 H/c	
7	Width Of Pellet Die	Drg. No.	158 H/c		
8	Grooves As Per Drawing	Drg. No.	12 x 8 x 3 H/c / 12 x 8 x 3 H/c		
9	Fitting Sizes on CNC Plate	Drg. No.	OK		
10	Drilling Area Surface Smoothness		OK		
11	Tapping Operator		H/c Shop	<div style="border: 1px solid black; padding: 5px;"> Tapping No. of Holes = 8 Both Side </div>	
12	Tapping PCD		454 H/c / 453.9 H/c		
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 = 18.4 H/c	Tapping Depth = 16.8 H/c	
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 = 18	
2	External Relief Dia.	5.0 H/c	0.03: 0.05	Inner	
3	External Relief Depth		4 H/c	Nil	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Pannore		
6	Material Sent For Hardening On Date		5/12/23		
Inspected By (Sign) & Date			Ravi 5/12/23		


 Reviewed by (Engineer (CNC))

Manager-QA