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	<b>Lark Engineering Co. (India)</b> ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (Haryana)	Form No.	CNC/QA/FM/02	
	<b>Inprocess Inspection (Pellet Dies)</b>		Rev. No.	01
			Rev. Date	31.07.2013

S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10111	30/40/65
2	Machined By		V.T.L n/c Shop	Drill No. 18.0. 311
3	Pellet Die No.		11160 (G.O) n/c	Rev. 03/01
4	Die category	Drg. No.	SSSTO	
5	Outside diameter	Drg. No.	638.14 n/c Step 00 = 640.14 / 652.7 n/c	
6	Inside Diameter	Drg. No.	508.8 n/c <sup>10 slot</sup> 529.3 n/c / 538.5 n/c	Tapper = 8°
7	Width Of Pellet Die	Drg. No.	175 n/c	Step length = 39 n/c / 30 n/c
8	Grooves As Per Drawing	Drg. No.	22 x 12 x 7 n/c / 30 x 21 x 7 n/c	Under cut = 21 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		574 n/c	[ Tapping No. of holes = 4 ]
13	Tapping Hole Diameter		M16. Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 11nd Side 4 slot	
15	Tapping Hole Depth		Drill Depth = 30.4 n/c	Tapping Depth = 30.7
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.		_____	[ 4 slot 51.4 n/c Long 28 n/c wide 15 n/c Deep ]
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		Rev
2	External Relief Dia.	6.5 n/c / 7.0 n/c	6.5 n/c All Lines / 7.0 n/c All Lines	
3	External Relief Depth		35 n/c / 35 n/c	
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*

*Satya*  
5/12/23  
Reviewed by (Engineer (CNC))

Manager-QA