


6567

	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.		10780	45/60
2	Machined By		V.T.L. H/c Shop	Dry No. 130-176
3	Pellet Die No.		10367 (4.0) H/H	Recess
4	Die category	Drg. No.	Ⓟ Jumbo	
5	Outside diameter	Drg. No.	819.8 H/H Step O.D.	799.9 H/H Step length 365
6	Inside Diameter	Drg. No.	780.12 H/H	
7	Width Of Pellet Die	Drg. No.	310 H/H	
8	Grooves As Per Drawing	Drg. No.	25x10x9 H/H 25x10x9 H/H	[Face Side step 0.3mm Depth Both Side]
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	[Tapping H/c of 1.45mm 12 Both Side]
11	Tapping Operator		H/c Shop	
12	Tapping PCD		750 H/H	
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		2.111 Depth 36.3 H/H	Tapping Depth 34 H/H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	


Inspected By (Sign) & Date Ravi G/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 - 4 Hole Closed	

Note: Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK		Recess 53
2	External Relief Dia.	4.5 H/H	outside (3-3) / Inner	
3	External Relief Depth		23 H/H / 15 H/H	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porwara	
6	Material Sent For Hardening On Date		G/12/23	

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


 6/12/23

Reviewed by (Engineer (CNC))

Manager-QA