

	<b>Lark Engineering Co. (India)</b>	Form No.	CNC/QA/FM02
	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.		10795	40/48/55
2	Machined By		V.T.L. H/C Shop	Drg. No. I.S.02566
3	Pellet Die No.		11370 (6.0) H/C	Rev 20
4	Die category	Drg. No.	N. Jumbo	
5	Outside diameter	Drg. No.	710 H/C Step 002	692.7 H/C Tapped 12°
6	Inside Diameter	Drg. No.	600.12 H/C	Step length 20 H/C
7	Width Of Pellet Die	Drg. No.	999 H/C	
8	Grooves As Per Drawing	Drg. No.	12 x 10 x 7.5 H/C / 12 x 10 x 7.5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of H. 12 = 12 Both Side
12	Tapping PCD		640 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 21.4 H/C	Tapping Depth 19 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 22
2	External Relief Dia.	6.5 H/C / 7.0 H/C	6.5 H/C All Lines	7.0 H/C All Lines	
3	External Relief Depth		15 H/C	7 H/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*

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

Manager-QA