


6828

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

S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10769	29/50
2	Machined By		V.T.L n/c Shop	By the 1:2 call 288
3	Pellet Die No.		10515 (2.8) n/c	Rev 02
4	Die category	Drg. No.	SSTD	
5	Outside diameter	Drg. No.	G24 n/c Step OD = 624 n/c	Step length 18 mm
6	Inside Diameter	Drg. No.	520.12 n/c	Tappers 12
7	Width Of Pellet Die	Drg. No.	186 n/c	Under cut = 2 mm
8	Grooves As Per Drawing	Drg. No.	13x8x5 mm 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No of holes 12 R-side
12	Tapping PCD		565 mm	
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, 20.8 mm	Tapping Depth 19 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 30/11/23

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		Rep 31
2	External Relief Dia.	3.3 mm	90° side 3-3	Inner
3	External Relief Depth	2.4 mm	2.4 mm	2.1 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		30/11/23	

Inspected By (Sign) & Date Ravi 30/11/23

Satyam
30/11/23
Reviewed by (Engineer (CNC))

Manager-QA