


6565

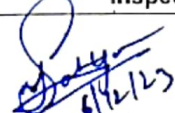
	Lark Engineering Co. (India)	Form No.	CNC/QA/FM/02
	ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (Haryana)	Rev. No.	01
	Inprocess Inspection (Pellet Dies)	Rev. Date	31.07.2013

S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10815 ✓	33/50 ✓
2	Machined By		V.T.C. N/c Shop	Dwg No. L.E.C-9990
3	Pellet Die No.		11071 (3.0) ✓	Rev. 00 ✓
4	Die category	Drg. No.	Extra wide	
5	Outside diameter	Drg. No.	619.9 ✓	Step 00 = Tapping 12 = Step length 18 mm
6	Inside Diameter	Drg. No.	590.14 ✓	
7	Width Of Pellet Die	Drg. No.	222 ✓	
8	Grooves As Per Drawing	Drg. No.	13x8=5 ✓ / 13x8=5 ✓	
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 Both Side
12	Tapping PCD		565 ✓	
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 = 21.3 ✓	Tapping Depth = 19 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 6/12/23	

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		Ravi 38
2	External Relief Dia.	3.5 ✓	Outside (3.3) / Inner	
3	External Relief Depth	✓	2.3 ✓ / 1.7 ✓	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		6/12/23	
Inspected By (Sign) & Date			Ravi 6/12/23	


 Reviewed by (Engineer (CNC))

Manager-QA