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Lark Engineering Company (India) Pvt. Ltd. I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)		Form No.	CNC/QA/FM/02
		Rev. No.	01
Inprocess Inspection (Pellet Dies)		Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10107	39/50
2	Machined By		V.T.L. M/c Shop	Dg No. LSD 872 Rev 00
3	Pallet Die No.		10790 (3.5) mm	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620.5 mm Step OD 622.6 mm	Tapper 12°
6	Inside Diameter	Drg. No.	520.12 mm	Step length 20 mm [15.53 4.47]
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	11 x 10 x 5 mm / 11 x 10 x 5 mm	Undercut 1 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	[Tapping No. of holes 12 Both 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 22.4 mm	Tapping Depth 20.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 18/8/23	
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 35
2	External Relief Dia	4.0 mm	Outside (3-3)		Inner			
3	External Relief Depth		18 mm		11 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		18	8	23			
	Inspected By (Sign) & Date		Ravi 18/8/23					

18/8/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner