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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
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13334	
2	Machined By		VTL-MIC Shop	34/40
3	Pallet Die No.		13041 (3.2) mm	Drg No 23 Roll
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	500 mm, OD Step-491 mm	Step height - 16.5
6	Inside Diameter	Drg. No.	420 mm	
7	Width of Pellet Die	Drg. No.	173 mm	
8	Grooves as per Drawing	Drg. No.	10 x 8.5 x 5 mm	Tapping No of Holes - 08
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		MIC Shop	
12	Tapping PCD		455 mm	
13	Tapping Hole Diameter		Ø 3/4" Check Ø 3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drilling Depth-20.2 mm Tapping Depth - 18.5 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		[signature] 20/11/24	
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						Counter - 60°
2	External Relief Dia	Ø 3.8	out side		dimmer			
3	External Relief Depth		10 mm	2.27	6 mm			
4	Inspection Done Before Hardening By (Name)		[signature]					
5	Material Sent For Hardening By (Name)		Harish Rajan					
6	Material Sent For Hardening On Date		20	11	24			
	Inspected By (Sign) & Date		[signature] 20/11/24					

[signature] 20/11/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner