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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.		13634	23/40
2	Machined By		V.T.L M/C Shop	Dry No. Lark SS10
3	Pallet Die No.		13194(3.2) MM	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 MM, Step OD = 395 MM	Step length 14.5
6	Inside Diameter	Drg. No.	320.12 MM	
7	Width of Pellet Die	Drg. No.	142 MM	
8	Grooves as per Drawing	Drg. No.	15.5x7x2 MM / 15.5x7x2 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 8 Both Side
12	Tapping PCD		355 MM	
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth = 20.3 MM Tapping Depth = 18.6 MM	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 27/12/24	
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° Row = 19
2	External Relief Dia	3.8 MM	Outside (2-2)		Inner			
3	External Relief Depth		20 MM		17 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		27	12	24			
	Inspected By (Sign) & Date		Ravi 27/12/24					

27/12/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner