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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.		9346	120/120
2	Machined By		V.T.L M/c Shop	Drg No: L.S.D: 559
3	Pallet Die No.		10464 (3.0) MM	Rev: 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	870 MM Step OD: 743.4 MM	Tapper: 10
6	Inside Diameter	Drg. No.	630.12 MM	Step length: 28.8
7	Width of Pellet Die	Drg. No.	265 MM	
8	Grooves as per Drawing	Drg. No.	15x8x5 MM / 15x8x5 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 - 16 Both Side
12	Tapping PCD		685 MM	
13	Tapping Hole Diameter		M20: Chack by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 MM Tapping Depth: 18.8 MM	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 6/6/23	
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: 18 Hole Colused (A)	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Row: 46
2	External Relief Dia	—	—	No - Relief				
3	External Relief Depth		—					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Keshav					
6	Material Sent For Hardening On Date		6	6	23			
	Inspected By (Sign) & Date		Ravi 6/6/23					

7/6/23

Reviewed by (Engineer-CNC)

Manager-QA