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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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14595	53/58
2	Machined By		V.T.L. H/c Shop	Dy. No. 12.0.811
3	Pallet Die No.		13781 (2.8) H/c	Rev. No.
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	635.9 H/c	Step on 611.9 H/c
6	Inside Diameter	Drg. No.	52.12 H/c	Step length 19.5
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		56.5 H/c	
13	Tapping Hole Diameter		H20. Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.6 H/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 15/4/25	
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 Sink
2	External Relief Dia	4.3 H/c	Outside (2.3-3)	Inner
3	External Relief Depth		12 H/c	5 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark For hard	
6	Material Sent For Hardening On Date		15 4 25	
Inspected By (Sign) & Date			Ravi 15/4/25	

Reviewed by (Engineer-CNC)

Manager-QA