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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.		10518	53/58
2	Machined By		V.T.L. M/c Shop	Drg No. L.S.D. 812
3	Pallet Die No.		9832 (3.8) MM	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	716MM, Step OD. 692MM	Step length. 19.5
6	Inside Diameter	Drg. No.	600.12MM	
7	Width of Pellet Die	Drg. No.	222MM	
8	Grooves as per Drawing	Drg. No.	12.5x8x7MM / 12.5x8x7MM	
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		645MM	
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. 22.4MM	Tapping Depth. 20.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 27/10/23	
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						Row. 33
2	External Relief Dia	4.3MM	Outside (3-3)		Inner			
3	External Relief Depth		12MM		5MM			
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	10	23			
	Inspected By (Sign) & Date		Ravi 27/10/23					

Satya 27/10/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner