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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.		10298 to 10762	39/50
2	Machined By		V.T.L. M/c Shop	Drg No. L.E.C. 9980
3	Pallet Die No.		10792 (3.0) mm	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 mm, Step OD, Tapper 12"	Step length 18.5
6	Inside Diameter	Drg. No.	520.12 mm / 520.14 mm	
7	Width of Pellet Die	Drg. No.	221.4 mm (A)	
8	Grooves as per Drawing	Drg. No.	11x10x5 mm / 11x10x5 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 12 Both Side
12	Tapping PCD		565 mm	
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 22.4 mm	Tapping Depth 20.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 16/11/23	
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 = 37
2	External Relief Dia	33 mm	outside (3-3)		Inner			
3	External Relief Depth		17 mm		11 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		16	11	23			
	Inspected By (Sign) & Date		Ravi 16/11/23					

Sotz 16/11/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner