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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.		10685	30/40
2	Machined By		V.T.L M/c Shop	Drg No. LS.D.21
3	Pallet Die No.		10716 (3.0) MM	Rev. 01
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 MM Step OD = 499 MM	Tapper 12°
6	Inside Diameter	Drg. No.	420.12 MM	Step length 17 MM
7	Width of Pellet Die	Drg. No.	158 MM	
8	Grooves as per Drawing	Drg. No.	12×8×3 MM / 12×8×3 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		454 MM	
13	Tapping Hole Diameter		~~[illegible]~~ Ø3/4" Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 MM Tapping Depth 16.8 MM	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 21/11/23	
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 = 25
2	External Relief Dia	3.5 MM	Outside (2-2)		Inner			
3	External Relief Depth		13 MM		10 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		21	11	23			
	Inspected By (Sign) & Date		Ravi 21/11/23					

Satya 21/11/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner