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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.		10654	60/60
2	Machined By		V.T.L M/c Shop	Drg No: E.S.D. 920
3	Pallet Die No.		7222 (6.0) MM	Rev: 00
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	670MM, Step OD: 673MM	Tapper: 12°
6	Inside Diameter	Drg. No.	550.1 MM	Step length: 30MM
7	Width of Pellet Die	Drg. No.	235 MM	Under cut: 1.5MM
8	Grooves as per Drawing	Drg. No.	24.5x8x9 MM / 24.5x8x9 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		620 MM / 620.1 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: 28.8MM	Tapping Depth: 26.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 18/11/23	
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: 21
2	External Relief Dia	6.5MM	Outside (2-2)		Inner			
3	External Relief Depth		6MM		Nill			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		18	11	23			
	Inspected By (Sign) & Date		Ravi 18/11/23					

18/11/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner