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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.		10854	49/50
2	Machined By		V.T.L. M/C. Shop	Drg No. I.E.C. 9980 Rev. 00
3	Pallet Die No.		11941 (4.0) HT	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 HT Step OD = Taper 12° Step length = 18	
6	Inside Diameter	Drg. No.	520.12 HT	
7	Width of Pellet Die	Drg. No.	9.92 HT	
8	Grooves as per Drawing	Drg. No.	13x8x5 HT / 13x8x5 HT	
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 HT	
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth = 21.3 HT Tapping Depth = 19 HT	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 16/12/23	
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						Rev: 31
2	External Relief Dia	4.3 HT	Outside (3.3)		Inner			
3	External Relief Depth		12 HT		8 HT			
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	12	23			
	Inspected By (Sign) & Date		Ravi 16/12/23					

Satya 16/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner