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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.		10949	33150
2	Machined By		V.T.L M/c Shop	Dy No. LEC/2501
3	Pallet Die No.		8840 (4.0) HH	Rev: 01
4	Die Category	Drg. No.	H. Turbo	
5	Out Side Diameter	Drg. No.	700 HH, Step OD: 693 HH	Step length: 20 HH
6	Inside Diameter	Drg. No.	600.12 HH	Tapper: 12°
7	Width of Pellet Die	Drg. No.	220 HH	
	Grooves as per Drawing	Drg. No.	12x8x7 HH / 12x8x7 HH	
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		640 HH	
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: 20.4 HH	Tapping Depth: 18.8 HH
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						Row: 32
2	External Relief Dia	4.5 HH	Outside (3.3)		Inner			
3	External Relief Depth		16 HH		12 HH			
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