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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.		10863	24/40
2	Machined By		V.T.L N/C Shop	Drg No: Lark 9109 SSTD
3	Pallet Die No.		11512 (3.5) NN	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 NN, Step OD = 395 NN	Step length = 14.5 NN
6	Inside Diameter	Drg. No.	320.12 NN	
7	Width of Pellet Die	Drg. No.	142 NN	
8	Grooves as per Drawing	Drg. No.	15.5×7×2 NN / 15.5×7×2 NN	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No of Holes, 8 Both Side
12	Tapping PCD		355 NN / 354.9 NN	
13	Tapping Hole Diameter		N16 = Check by N16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 21.4 NN Tapping Depth, 19 NN	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 22/12/23	
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 — 1 Hole Closed (D)	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Row = 18
2	External Relief Dia	3.8 NN	Outside (2-2)		Inner			
3	External Relief Depth		20 NN		16 NN			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		22	12	23			
	Inspected By (Sign) & Date		Ravi 22/12/23					

Satya 22/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner