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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.		11108	87/40
2	Machined By		V. T. L. n/c Shop	Drg No: 1-3-0
3	Pallet Die No.		10955 (3.0) n/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c, Step OD = 491 n/c	Step length = 17.4
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	158.1 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c / 12x8x3 n/c	
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		454 n/c	
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 = 19.5 n/c Tapping Depth = 17.4	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi Gulil24

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

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

Counter = 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5 n/c	outside (2-2)		Inner				
3	External Relief Depth		16 n/c		13 n/c				
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Parnare						
6	Material Sent For Hardening On Date		24	1	24				

Inspected By (Sign) & Date

Ravi Gulil24

Reviewed by (Engineer-CNC)
Saty 24/11/14

Manager-QA