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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.		10817	33/50
2	Machined By		V.T.L H/C Shop	Dy No. L.E.C.-990 Rev-00
3	Pallet Die No.		11104 (3.0) HH	
4	Die Category	Drg. No.	Carbowide	
5	Out Side Diameter	Drg. No.	620 HH Step OD. Tapper 12° Step length 18mm	
6	Inside Diameter	Drg. No.	520.12 HH / 520.14 HH	
7	Width of Pellet Die	Drg. No.	222 HH	
8	Grooves as per Drawing	Drg. No.	13x8x5 HH / 13x8x5 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		H/C Shop	Tapping No of Holes = 12 Both Side
12	Tapping PCD		565 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 = 21 HH Tapping Depth = 18.8 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 19/2/24	
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

Counter — 60°

1	Counter Sinking Depth & Finish	Ok						Rad: 38
2	External Relief Dia	3.5 HH	Out Side (3-3)		Inner			
3	External Relief Depth		23 HH		17 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		19	2	24			
	Inspected By (Sign) & Date		Ravi 19/2/24					

19/2/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner