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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.		11619	37/50
2	Machined By		V.T.L M/c Shop	Drg No. 63.0.947
3	Pallet Die No.		11053 (3.5) mm	Rev 01
4	Die Category	Drg. No.	SEN	
5	Out Side Diameter	Drg. No.	520 mm, Step OD = 499 mm	Step length 17 mm
6	Inside Diameter	Drg. No.	420.12 mm	Tapper 12°
7	Width of Pellet Die	Drg. No.	182 mm	
8	Grooves as per Drawing	Drg. No.	10×8×3 mm / 10×8×3 mm	
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 = 8 Both Side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		03/4" = Check by 03/4" Roll	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 18.6 mm Tapping Depth = 16.8 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 17/4/24	
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

1	Counter Sinking Depth & Finish	ok						Row = 28
2	External Relief Dia	4.0 mm		All Rows				
3	External Relief Depth			13 mm				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		17	4	24			
	Inspected By (Sign) & Date		Ravi 17/4/24					

17/4/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner