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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.		9952	35/50 6955 By No. Lark5570
2	Machined By		V.T.L H/C Shop	
3	Pallet Die No.		10615 (8.0) HH	
4	Die Category	Drg. No.	End sawide	
5	Out Side Diameter	Drg. No.	619.8 HH ⓐ Step OD 611.8 HH	Step length 19.4
6	Inside Diameter	Drg. No.	520.12 HH	
7	Width of Pellet Die	Drg. No.	22.2 HH	
8	Grooves as per Drawing	Drg. No.	13×8×5 HH / 13×8×5 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. 20.4 HH Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 24/7/23	
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							Rev 2 18
2	External Relief Dia	8.5 HH	Outside (3-3)		Inner				
3	External Relief Depth		23 HH		15 HH				
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Bhat Metal						
6	Material Sent For Hardening On Date		24	7	23				
	Inspected By (Sign) & Date		Ravi 24/7/23						

26/7/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner