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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.		12121	32/42/50
2	Machined By		V.T.L M/C Shop	Drg No. LSD 633
3	Pallet Die No.		11665 (4.0 mm)	(Rev 01)
4	Die Category	Drg. No.	SSS TD	
5	Out Side Diameter	Drg. No.	620 mm Step OD - 623.6 mm	Step Length - 20 mm
6	Inside Diameter	Drg. No.	520.12 mm	Taper - 12°
7	Width of Pellet Die	Drg. No.	186 mm	Undercut - 1.8 mm
8	Grooves as per Drawing	Drg. No.	13X8X5mm / 13X8X5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of
10	Drilling Area Surface Smoothness		ok	Holes 12
11	Tapping Operator		M/C Shop	Both Side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 20.7 mm Tapping Depth - 18.7 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ramanpreet Singh 04/6/24	
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						RCW - 25
2	External Relief Dia		4.5 mm	5.0 mm				
3	External Relief Depth		18 mm	8 mm				
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		04	6	24			
	Inspected By (Sign) & Date		Ramanpreet Singh 04/6/24					

Reviewed by (Engineer-CNC) 4/6/24.

Manager-QA

Scanned with CamScanner