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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.		12404	35/55
2	Machined By		V.T.L M/c Shop	Drg No. L.S.D. 755
3	Pallet Die No.		11443(4.5) MM	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	737 MM Step OD = 754.3 MM	
6	Inside Diameter	Drg. No.	630 MM / Bore = 627 MM	Tapper = 10°
7	Width of Pellet Die	Drg. No.	256 MM	Step length = 29 MM
8	Grooves as per Drawing	Drg. No.	19.5x10x8 MM / 19.5x10x8 MM	Under cut = 8.65 MM
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		689 MM	Tapping No. of holes = 12 Both Side
13	Tapping Hole Diameter		M24 = Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth 28.4 MM	Tapping Depth = 26.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 30/7/24	
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						Counter = 60° Raw = 31
2	External Relief Dia	5.0 MM	Outside (3-3)		Inner			
3	External Relief Depth		25 MM		20 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		30	7	24			
	Inspected By (Sign) & Date		Ravi 30/7/24					

Satya 30/7/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner