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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.		12966	26/66
2	Machined By		V.T.L M/C Shop	28/66
3	Pallet Die No.		13337 (6.0) mm	Drg No. (1.3.2-320
4	Die Category	Drg. No.	M. Jumbo	Rev. 06
5	Out Side Diameter	Drg. No.	680.1 mm, Step OD = 693 mm	Tapper = 8°
6	Inside Diameter	Drg. No.	548 mm / 547.12 mm	Step length = 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut = 2.8 mm
8	Grooves as per Drawing	Drg. No.	32×7×8 mm / 32×7×8 mm (4×8)	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Face Side Step
10	Drilling Area Surface Smoothness		ok	2 mm Deep Both
11	Tapping Operator		M/C Shop	Side
12	Tapping PCD		619 mm	[Tapping No.
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	of Holes = 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side]
15	Tapping Hole Depth		Drill Depth = 34.4 mm	Tapping Depth = 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 17/10/24	
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 = 30°

1	Counter Sinking Depth & Finish	ok						Rev = 12
2	External Relief Dia	7.0 mm	Ist Pad		IInd Pad			
3	External Relief Depth		40 mm		38 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	10	24			
	Inspected By (Sign) & Date		Ravi 17/10/24					

Satya 18/10/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner