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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.		13041	30/66
2	Machined By		V.T.L M/C Shop	32/66
3	Pallet Die No.		12939 (8.0) mm	Drg No. LS.D.609
4	Die Category	Drg. No.	M.Jumbo	4x3 Rev 01
5	Out Side Diameter	Drg. No.	680.7 mm, Step OD 693 mm	Tapper 8°
6	Inside Diameter	Drg. No.	548.1 mm	Step length 9 mm
7	Width of Pellet Die	Drg. No.	195 mm	Undercut 2.5 mm
8	Grooves as per Drawing	Drg. No.	32x7x8 mm | 32x7x8 mm	(4x8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		Ok	[Face side Step 2 mm Deep Both side]
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619 mm	[Tapping No of holes 9 Both Side]
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 34.8 mm	Tapping Depth 31.8
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						Row 10
2	External Relief Dia	9.0 mm	1st Pad		2nd Pad			
3	External Relief Depth		36 mm		34 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					

18/10/24.

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner