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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.		13681	36/45
2	Machined By		V.T.L. M/c Shop	Dwg No. LS.D.302 Rev 00
3	Pallet Die No.		13127 (6.0) mm	
4	Die Category	Drg. No.	SED	
5	Out Side Diameter	Drg. No.	510 mm, Step OD = 491 mm	Step length = 16.5
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	173 mm	
8	Grooves as per Drawing	Drg. No.	10x8.5 x 5mm / 10x8.5x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No of holes: 8 Both Side
12	Tapping PCD		455 mm	
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.2 mm	Tapping Depth = 18.6 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 26/12/24	
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° Holes 17
2	External Relief Dia	6.5mm	Outside (2.2)		Inner			
3	External Relief Depth		15mm		9mm			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		26	12	24			
	Inspected By (Sign) & Date		Ravi 26/12/24					

Satya 26/12/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner