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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.		12459	32/32
2	Machined By		V.T.L. M/c Shop	Drg No. 13.2.1.97
3	Pallet Die No.		13152(1.2) MM	Rev 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	594 MM / Step OD - 682 MM / 596 MM	
6	Inside Diameter	Drg. No.	530.12 MM / 530.2 MM (A)	Step length 27 MM 17.5 MM
7	Width of Pellet Die	Drg. No.	278 MM	Undercut 44 MM
8	Grooves as per Drawing	Drg. No.	27x8x8 MM / 43x8x8 MM	
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
12	Tapping PCD		594 MM	
13	Tapping Hole Diameter		M16, Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and IInd Side One Slot	
15	Tapping Hole Depth		Drill Depth 25.3 MM Tapping Depth 23.4 MM	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 30/1/25	1 Slot 29.1 MM width 18 MM Deep
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 - 15 Hole Closed (A)	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter 45° Rows 140
2	External Relief Dia	—	—	No	Relief			
3	External Relief Depth		—					
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	1	25			
	Inspected By (Sign) & Date		Ravi 30/1/25					

Satya 30/1/25

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner