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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.		14035	28/50
2	Machined By		V.T.L M/c Shop	Drg No. L.S.D = 344
3	Pallet Die No.		12019 (2.8) MM	Row = 09
4	Die Category	Drg. No.	NJ&W	
5	Out Side Diameter	Drg. No.	700 MM, Step OD = 692 MM	Step length 19.5
6	Inside Diameter	Drg. No.	600.12 MM	
7	Width of Pellet Die	Drg. No.	265 MM	
8	Grooves as per Drawing	Drg. No.	15x8x7 MM / 15x8x7 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 = 16 Both Side
12	Tapping PCD		640 MM	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.3 MM	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 29/1/25	
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 - 1 Hole Colosed	

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

Counter = 6

1	Counter Sinking Depth & Finish	ok						Row = 49
2	External Relief Dia	3.3 MM	outside (3.3)		Inner			
3	External Relief Depth		25 MM		22 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		29	1	25			
	Inspected By (Sign) & Date		Ravi 29/1/25					

Satya 29/1/25

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner