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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.		13975	40/55
2	Machined By		V.T.L M/c Shop	Drg No. LEC 14951
3	Pallet Die No.		13582 (4.0) MM	Rev 00
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	630 MM, Step OD = 621.5 MM	Tapper 12°
6	Inside Diameter	Drg. No.	520.1 MM (Bor = 519.8 MM)	Step length 21.5
7	Width of Pellet Die	Drg. No.	222 MM (D)	
8	Grooves as per Drawing	Drg. No.	13x8x5 MM / 13x8x5 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 = 12 Both Side
12	Tapping PCD		565 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 = 18.64
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	

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

1	Counter Sinking Depth & Finish	ok						Counter = 60° Row = 31
2	External Relief Dia	4.5 MM	Outside (3.3)		Inner			
3	External Relief Depth		19 MM		15 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