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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.		11034	32/40/50
2	Machined By		V.T.L. M/c Shop	Drg No. 1.3.2.259
3	Pallet Die No.		11445 (4.0) MM	Rev. 02
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	620 MM, Step OD: 622.4 MM	Tapper 12
6	Inside Diameter	Drg. No.	520.12 MM / 520.14 MM	Step length 18 MM
7	Width of Pellet Die	Drg. No.	222 MM	Undercut 1.2 MM
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 = 21.4 MM Tapping Depth 18.8 MM	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 12/1/24	
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 60°

1	Counter Sinking Depth & Finish	ok						Row 31
2	External Relief Dia	4.3 MM / 4.8 MM	4.3 MM	All Rows	4.8 MM	All Rows		
3	External Relief Depth		18 MM			10 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		12	1	24			
	Inspected By (Sign) & Date		Ravi 12/1/24					

Satya 12/01/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner