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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.		11139	33/53/66
2	Machined By		V.T.L M/c Shop	Drg No. L.S.D. 609
3	Pallet Die No.		11491 (6.0) MM	Rev. 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 MM, Step OD 692.8 MM	Tapper 8°
6	Inside Diameter	Drg. No.	548.12 MM	Step length 31 MM
7	Width of Pellet Die	Drg. No.	195 MM	Under cut 2.4 MM
8	Grooves as per Drawing	Drg. No.	32×7×8 MM / 32×7×8 MM	(4×8) MM
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 8 MM
10	Drilling Area Surface Smoothness		ok	Deep Both Side
11	Tapping Operator		M/c Shop	Tapping No.
12	Tapping PCD		619 MM	of Holes 4
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.4 MM	Tapping Depth 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 30/1/24	
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 30°

1	Counter Sinking Depth & Finish	ok						Row 12
2	External Relief Dia	6.5 MM / 7.0 MM	6.5 MM	All Rows	7.0 MM	All Rows		
3	External Relief Depth		33 MM			13 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		30	1	24			
	Inspected By (Sign) & Date		Ravi 30/1/24					

30/1/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner