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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.		10929	55/66
2	Machined By		V.T.L M/c Shop	Drg No. 1.2C.9136
3	Pallet Die No.		11769 (3.5) MM	Rev. 01
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1032.2 MM Step OD = 1033 MM	Tapper = 3°
6	Inside Diameter	Drg. No.	900.12 MM / 900.14 MM	Step length = 37 MM
7	Width of Pellet Die	Drg. No.	375 MM	36.2 MM
8	Grooves as per Drawing	Drg. No.	29.5×8×13 MM / 29.4×8×13 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 = 15 Both Side
12	Tapping PCD		970 MM	
13	Tapping Hole Diameter		M24 = Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 39 MM	Tapping Depth = 36.6 MM
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 10/2/24	
1	As per programme no.		—	2 Slot 32.1 MM width 7.5 MM Deep Both Side
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 = 59
2	External Relief Dia	4.0 MM	Outside (4-4)		Inner			
3	External Relief Depth		18 MM		11 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		10	2	24			
	Inspected By (Sign) & Date		Ravi 10/2/24					

Satyam 10/2/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner