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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.		10259	30/40/62
2	Machined By		V.T.L M/c Shop	Drg No. L.S.D. 341
3	Pallet Die No.		11539 (6-0) MM	Rev. 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	754.5 MM, Step OD = 756.5 MM / 766.1 MM	
6	Inside Diameter	Drg. No.	630.1 MM / 660.4 MM / 642.8 MM	Tapper = 5°
7	Width of Pellet Die	Drg. No.	136 MM	Step length = 40 MM
8	Grooves as per Drawing	Drg. No.	26 x [20 x 8 x 8] MM (step 10) / 14 x [4.5 x 8 x 8] MM (10 step)	20 MM, Undercut = 1 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 Holes and Both Side M12 = 8 Holes
12	Tapping PCD		M20 = 712 MM / M12 = 682 MM	
13	Tapping Hole Diameter		M20 / M12 Check by M20 / M12 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 45.6 MM / 24.6 MM	Tapping Depth = 43.5 MM / 22 MM
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 29/2/24	M20 Tapping side 3 slot 20 MM wide 6 MM Deep
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 = 30° Row = 6
2	External Relief Dia	6.5 MM / 7.0 MM	6.5 MM All Rows		7.0 MM All Rows			
3	External Relief Depth		32 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	2	24			
	Inspected By (Sign) & Date		Ravi 29/2/24					

Satya 29/2/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner