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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.		13814	45/50
2	Machined By		V.T.L H/C Shop	Dy No. 1.2C.1969 Rev. 01
3	Pallet Die No.		13843(4.0) HH	
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	760 HH Step OD. 792 HH	Step length 27 HH Under cut 10 HH
6	Inside Diameter	Drg. No.	660.12 HH	
7	Width of Pellet Die	Drg. No.	32.4 HH	
8	Grooves as per Drawing	Drg. No.	21x8x10 HH / 21x8x10 HH	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		H/C Shop	Tapping No. of holes 12 Both Side
12	Tapping PCD		725 HH	
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. 27.2 HH Tapping Depth. 25.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 6/1/25	
1	As per programme no.		—	2 Slot 32.1 HH width 9 HH Depth Both Side
2	Gun Drilling Work Completed On		—	
3	Hole Finish In Gun Drilling	Marked	Ok	
4	Defective Holes (If Any)		No — 1 Hole Closed (A)	

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

Counter Go Ring 48

1	Counter Sinking Depth & Finish	Ok						
2	External Relief Dia	4.5HH	Out Side (3.3)		Inner			
3	External Relief Depth		13HH		5HH			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		6	1	25			
	Inspected By (Sign) & Date		Ravi 6/1/25					

Reviewed by (Engineer-CNC) 7/1/25.

Manager-QA

Scanned with CamScanner