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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.		14344	40/40
2	Machined By		V.T.L M/C Shop	Drg No. 18.D.574
3	Pallet Die No.		14356(3.5)MM	Rev 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	385MM Step OD 383MM	Step length 9.5
6	Inside Diameter	Drg. No.	304.12 MM / 305.12 MM	
7	Width of Pellet Die	Drg. No.	127 MM	ID Rework
8	Grooves as per Drawing	Drg. No.	8x6x3 MM / 8x6x3 MM	in final
9	Fitting Sizes on CNC Plate	Drg. No.	ok	machining
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No.
12	Tapping PCD		350MM	of Holes 8
13	Tapping Hole Diameter		M12 = Check by M12 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3MM	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 8/3/25	
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 = 17
2	External Relief Dia	4.0MM	outside (2-2)		Inner			
3	External Relief Depth		4MM		Nill			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		8	3	25			
	Inspected By (Sign) & Date		Ravi 8/3/25					

8/3/25

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner