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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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14428	28/38/86
2	Machined By		V.T.L. H/C Shop	Dy No: U.D. 6-9 Rev=03
3	Pallet Die No.		14746 (6.0) HH	
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 HH, Step OD: 693 HH	Tapper = 8°
6	Inside Diameter	Drg. No.	546.12 HH (Box: 548.4 HH)	Step length: 31 HH
7	Width of Pellet Die	Drg. No.	195 HH	Undercut = 2.5 HH
8	Grooves as per Drawing	Drg. No.	32x7x9.2 HH / 32x7x9.2 HH	(4 nos)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 HH x Deep
11	Tapping Operator		H/C Shop	Both Side
12	Tapping PCD		619 HH	Tapping No
13	Tapping Hole Diameter		M18 = Check by M18 Bolt	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth: 33.2 HH	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Raul 22/3/25	
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 = 30°

1	Counter Sinking Depth & Finish	ok						Rows 12
2	External Relief Dia	6.5 HH / 7.0 HH	6.5 HH	All Rows = 98 HH				
3	External Relief Depth	—	7.0 HH	All Rows = 98 HH				
4	Inspection Done Before Hardening By (Name)		Raul					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		22	3	25			
	Inspected By (Sign) & Date		Raul 22/3/25					

Reviewed by (Engineer-CNC) 24/3/25

Manager-QA