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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.		14630	33/QC
2	Machined By		V.T.L. M/c Shop	Dy No. 28.5.09 Rev 03
3	Pallet Die No.		14808 (B.O) mm	
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm Step OD = 693 mm	Tapper 8°
6	Inside Diameter	Drg. No.	546.12 mm (Bore = 548.4 mm)	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut = 8.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm | 32 x 7 x 9.0 mm	(4 x 8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 mm Deep Both Side
11	Tapping Operator		M/c. Shop	
12	Tapping PCD		619 mm	Tapping No
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	of Holes = 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 mm	Tapping Depth 31.0
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 13/4/25	
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

1	Counter Sinking Depth & Finish	ok						Counter = 30 Rows = 12
2	External Relief Dia	7.5 mm		All Rows				
3	External Relief Depth			33 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		13	4	25			
	Inspected By (Sign) & Date		Ravi 13/4/25					

Satya 13/4/25

Reviewed by (Engineer-CNC)

Manager-QA