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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.		14735	6866
2	Machined By		V.T.L M/c Shop	Dy No. 18.2.09 Rev. 03
3	Pallet Die No.		14977 (12.0) mm	
4	Die Category	Drg. No.	R-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	Undercut = 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm / 32 x 7 x 9.2 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 of Holes 2 Both Side
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.4 mm	Tapping Depth = 31.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 22/4/25	
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 = 80° Row = 6
2	External Relief Dia	—	—	No	Relief			
3	External Relief Depth		—		—			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace.					
6	Material Sent For Hardening On Date		22	4	25			
	Inspected By (Sign) & Date		Ravi 22/4/25					

Satya 22/4/25.

Reviewed by (Engineer-CNC)

Manager-QA