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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.		14829	40/50
2	Machined By		V.T.L. M/c Shop	Dwg. No. LEC 14805
3	Pallet Die No.		14596(4.0) MM	Rev. 02
4	Die Category	Drg. No.	M7&D	
5	Out Side Diameter	Drg. No.	700.9 MM	Step OD. Tapper. 12°
6	Inside Diameter	Drg. No.	Φ00.12 MM / Φ00.14 MM	Step leg ht. 17.1
7	Width of Pellet Die	Drg. No.	865 MM	
8	Grooves as per Drawing	Drg. No.	15×8×7 MM / 15×8×7 MM	Face Side Step 08 MM Both Side
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	Side
11	Tapping Operator		M/c Shop	Tapping No. of holes. 16
12	Tapping PCD		640 MM	
13	Tapping Hole Diameter		M20 × Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth. 20.4 MM	Tapping Depth. 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 29/4/25	
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. Bo. Ravi. 39
2	External Relief Dia	4.5 MM	Outside (3-3)		Inner			
3	External Relief Depth		14 MM		10 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		29	4	25			
	Inspected By (Sign) & Date		Ravi 29/4/25					

Satya 29/4/25.

Reviewed by (Engineer-CNC)

Manager-QA