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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.		14925	30/40
2	Machined By		V.T.L M/c Shop	Dynamic L.S.G 15062 Remark
3	Pallet Die No.		15072	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm, Step OD: 498.88	Taper: 12° Step length: 18 mm
6	Inside Diameter	Drg. No.	420.14 mm	
7	Width of Pellet Die	Drg. No.	157.7 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm / 12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No of Holes 8 Both Side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20 Check by Ring Roll	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 mm Tapping Depth 16.6 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 23/5/25	
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 — 3 Hole Colour col	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 60 Rows - 26

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	3.3 mm	Outside (2+2)		Inner			
3	External Relief Depth		16 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		23	5	25			
	Inspected By (Sign) & Date		Ravi 23/5/25					

Satya 23/5/25.

Reviewed by (Engineer-CNC)

Manager-QA