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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.		14920	33/66
2	Machined By		V.T.L H/a Shop	35/66
3	Pallet Die No.		15034 (8.0) mm	Drg No. 18.0.320
4	Die Category	Drg. No.	M. Turbo	Rev. 08
5	Out Side Diameter	Drg. No.	680.1 mm, Step OD: 693 mm	Taper: 8°
6	Inside Diameter	Drg. No.	548.12 mm (Box: 548.2 mm)	Step length: 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut: 2.8 mm
8	Grooves as per Drawing	Drg. No.	32×7×9.1 mm | 32×7×9.1 mm	(4×8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	Face Side Step
10	Drilling Area Surface Smoothness		Ok	2 mm Deep Both
11	Tapping Operator		H/a Shop	Side
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: 33.3 mm	Tapping Depth: 31.5
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	

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

1	Counter Sinking Depth & Finish	Ok					Counter: 90° Rev: 12
2	External Relief Dia	9.0 mm	Ist Pad	Ist Pad			
3	External Relief Depth		33 mm	31 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