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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.		15106	58/GC
2	Machined By		V.T.L. H/C Shop	Drg No. US-2320
3	Pallet Die No.		15217 (9.0) mm	Rev. 08
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 mm Step OD 698 mm (Chamfer 4x45)	Tapper. 8°
6	Inside Diameter	Drg. No.	546.12 mm (Bor. 548.2 mm)	Step length. 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Undercut. 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
10	Drilling Area Surface Smoothness		ok	Step 2 mm Dot
11	Tapping Operator		H/O Shop	Both 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. 33.4 mm	Tapping Depth. 31.5 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 9/6/25	
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. Go Row = 8
2	External Relief Dia	10.0 mm	All	Rows				
3	External Relief Depth			8 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		9	6	25			
	Inspected By (Sign) & Date			Ravi 9/6/25				

Satyam 9/6/25.

Reviewed by (Engineer-CNC)

Manager-QA