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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.		15136	30/50
2	Machined By		V.T.L. M/c Shop	Dy No. 68.0.633
3	Pallet Die No.		13249(4.0) mm	Rawal
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	620 mm, Step OD. 623 mm	Tapper 12°
6	Inside Diameter	Drg. No.	520.14 mm	Step length 10 mm
7	Width of Pellet Die	Drg. No.	186 mm	Undercut 1.5 mm
8	Grooves as per Drawing	Drg. No.	13×8×5 mm / 13×8×5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565 mm	Tapping No. of holes 12 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 20.4 mm	Tapping Depth 18 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Rai 9/6/25	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
4	Defective Holes (If Any)		ok	
	Note : Mark the defective holes/Missed holes with the help of Permanent Marker		No	
1	Counter Sinking Depth & Finish	ok		Counter Bo. Rev. 25
2	External Relief Dia	4.5 mm	Outside 23-25	
3	External Relief Depth		24 mm	Inner 20 mm
4	Inspection Done Before Hardening By (Name)		Rai	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		9 6 25	
	Inspected By (Sign) & Date		Rai 9/6/25	

Satya 9/6/25

Reviewed by (Engineer-CNC)