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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.		15217	55/66
2	Machined By		V.T.L. M/C Shop	Drg No. LSD.32
3	Pallet Die No.		15330 (8.0) mm	Rev. 08
4	Die Category	Drg. No.	M. Jumbo	Grade 4-B
5	Out Side Diameter	Drg. No.	680.1 mm, Step OD = 693 mm	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	Under cut 2.8 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 mm / 32 x 7 x 9.1 mm	(4 x 8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Race Side Step
10	Drilling Area Surface Smoothness		ok	2 mm Deep
11	Tapping Operator		M/C Shop	Both Side]
12	Tapping PCD		619 mm	[Tapping No
13	Tapping Hole Diameter		M16, Check by M16 Bolt	of Holes &
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side]
15	Tapping Hole Depth		Drill Depth. 33.4 mm	Tapping Depth = 31.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 19/6/25	
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. 30° Rev. 10
2	External Relief Dia	9.0 mm		All Rows				
3	External Relief Depth			11 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		19	6	25			
	Inspected By (Sign) & Date		Ravi 19/6/25					

Satish 19/6/25

Reviewed by (Engineer-CNC)

Manager-QA