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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.		15159	36/64/78
2	Machined By		V.T.L. H/a Shop	Dy No. 1.3.2 Rev = 00
3	Pallet Die No.		15370 (6.5) mm	
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	636 mm / 632 mm Stck OD = 630.4 mm / 543 mm	
6	Inside Diameter	Drg. No.	48.12 mm / 489.12 mm / 500.12	Stck length 96 6.5
7	Width of Pellet Die	Drg. No.	182 mm	
8	Grooves as per Drawing	Drg. No.	37×12×8×9.5 mm / 27×12×8×9.5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No of holes 4
12	Tapping PCD		540 mm	
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one Side Tapping and Thd Side One Side	
15	Tapping Hole Depth		Drill Depth = 29 mm Tapping Depth 25 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 23/6/25	
1	As per programme no.		—	1 Slot 28.1 mm width 17 mm Depth
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

Counter Bo Rod 29

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	7.0 mm / 7.5 mm	7.0 mm	All Rods = 42				
3	External Relief Depth		7.5 mm	All Rods = 14				
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	6	25			
	Inspected By (Sign) & Date		Ravi 23/6/25					

23/6/25

Reviewed by (Engineer-CNC)

Manager-QA