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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.		15353	40/50
2	Machined By		V.T.L H/C Shop	Dy. H. L.S.D. 21 Rev 00
3	Pallet Die No.		15127 (4.0) mm	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 mm Step OD = 499 mm	Tapper 12
6	Inside Diameter	Drg. No.	420.14 mm	Step length 17 mm
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm / 12 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping H. of Lineer 8 Both Side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		03/4" Crack by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.4 mm Tapping Depth 19.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 2/7/25	
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

Counter: 60 Ravi 20

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.5 mm	Out side 22.25		Inner			
3	External Relief Depth		12 mm		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		2	7	25			
	Inspected By (Sign) & Date		Ravi 2/7/25					

Satya 2/7/25

Reviewed by (Engineer-CNC)

Manager-QA