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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.		15718	45/50
2	Machined By		V.T.L M/c Shop	Drg. No. LEC-743 Rev. 03
3	Pallet Die No.		18011 (3.5) MM	
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	760 MM Step OD. 773 MM	
6	Inside Diameter	Drg. No.	660.14 MM	Step length 8 MM
7	Width of Pellet Die	Drg. No.	323.7 MM	Under cut = 16.3 MM
8	Grooves as per Drawing	Drg. No.	31.5 x 8 x 12 MM / 31.5 x 8 x 12 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping No of holes = 12 Both Side
12	Tapping PCD		725 MM	
13	Tapping Hole Diameter		M20 Crack by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 31.4 MM	Tapping Depth 28.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 30/8/25	
1	As per programme no.		—	2 Slot 32.1 MM wide x 8 MM Deep Both Side
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. 60° Rev. 52
2	External Relief Dia	4.0 MM	80 Side (3.3)		Inner			
3	External Relief Depth		12 MM		5 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		30	8	25			
	Inspected By (Sign) & Date		Ravi 30/8/25					

Satya 30/8/25

Reviewed by (Engineer-CNC)

Manager-QA