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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.		15457	80/105
2	Machined By		V.T.L m/c Shop	Dy No. 1.8.0.170 Rework
3	Pallet Die No.		16327 (8.0) mm	
4	Die Category	Drg. No.	3. Jumbo	
5	Out Side Diameter	Drg. No.	1059.7 mm / Step OD: 1077 mm	Tapper .8°
6	Inside Diameter	Drg. No.	848.14 mm (Box: 850.4) mm	Step length = 4d
7	Width of Pellet Die	Drg. No.	266 mm	Cylen cut: 3.5 mm
8	Grooves as per Drawing	Drg. No.	45×8×9.2 mm / 45×8×9.2 mm	(8×8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 8 mm Deep Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		m/c Shop	
12	Tapping PCD		951.9 mm	Tapping No. of holes 8 Both Side
13	Tapping Hole Diameter		M20: Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 42.4 mm	Tapping Depth 39.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Rai 2/9/25	
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 Bo: Rows 14

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	9.0 mm	All holes					
3	External Relief Depth			45 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		2	9	25			
	Inspected By (Sign) & Date		Rai: 2/9/25					

Satya 2/9/25.

Reviewed by (Engineer-CNC)

Manager-QA