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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.		15577	33/48/70
2	Machined By		V.T.L M/C Shop	Dy No. 18.0.377
3	Pallet Die No.		14342 (6.0) MM	Rev 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 MM, Step OD. 697.7 MM	
6	Inside Diameter	Drg. No.	546.12 MM (Bor = 548.4)	Tapper. 5°
7	Width of Pellet Die	Drg. No.	215 MM	Step length. 38.5
8	Grooves as per Drawing	Drg. No.	29.5×10×9.2 MM / 29.5×10×9.2	Groove cut = 1.8 MM
9	Fitting Sizes on CNC Plate	Drg. No.	ok	(6×8) MM
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		M/C Shop	1MM Deep Both Side
12	Tapping PCD		618 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. 32.4 MM	Tapping Depth 30.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 12/9/25	
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

1	Counter Sinking Depth & Finish	ok						Counter. 30° Rows 14
2	External Relief Dia	6.5 MM / 7.3 MM	6.5 MM All Rows		37 MM			
3	External Relief Depth		7.3 MM All Rows		22 MM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Forrace					
6	Material Sent For Hardening On Date		12	9	25			
	Inspected By (Sign) & Date		Ravi 12/9/25					

Satya 12/9/25

Reviewed by (Engineer-CNC) Manager-QA