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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.		INV 10/6094.	36/50
2	Machined By		V.T.L M/c Shop	Dy H. 20x8x10
3	Pallet Die No.		15521 (3.0) MM	
4	Die Category	Drg. No.	9 rotsa wide	
5	Out Side Diameter	Drg. No.	620 MM, Step OD. 611.9 MM	
6	Inside Diameter	Drg. No.	520.14 MM / 519.MM (Box 520 MM) Step length 19.8	
7	Width of Pellet Die	Drg. No.	222.6 MM	
8	Grooves as per Drawing	Drg. No.	13.3x8x5 MM / 13.3x8x5 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side
10	Drilling Area Surface Smoothness		ok	Step 0.8 MM
11	Tapping Operator		M/c Shop	Deep Both Side
12	Tapping PCD		565 MM	Tapping No
13	Tapping Hole Diameter		M20, Check by M20 Bolt	of holes 12
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 20.6 MM Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 18/9/25	
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, Q.

1	Counter Sinking Depth & Finish	ok						Ravi 18/9/25
2	External Relief Dia	3.5 MM	Out Side (3-3)		Inner			
3	External Relief Depth		20 MM		14 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		18	9	25			
	Inspected By (Sign) & Date		Ravi 18/9/25					

Satya 18/9/25.

Reviewed by (Engineer-CNC)

Manager-QA