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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.		16054	32140
2	Machined By		V.T.I M/c Shop	Dry No = 12.0.942
3	Pallet Die No.		15698 (3.0) mm	Rev = 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	600 mm	Step OD = 621.4 mm
6	Inside Diameter	Drg. No.	520.14 mm	Tapper. 12°
7	Width of Pellet Die	Drg. No.	222 mm	Step length. 21.5 mm
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	Under cut. 10.7 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping Hole of holes. 12 Both Side
12	Tapping PCD		585 mm	
13	Tapping Hole Diameter		M10 x 1 Check by M10 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 mm	Tapping depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
	Inspected By (Sign) & Date		Ravi 19-9-25	
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. 60° Rows = 38
2	External Relief Dia	3.3 mm		All Rows				
3	External Relief Depth			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			19	9	25		
	Inspected By (Sign) & Date		Ravi 19-9-25					

19/9/25

Reviewed by (Engineer-CNC)

Manager-QA