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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.		16178 to 16366	36/50
2	Machined By		V.T.L M/c Shop	Day Hon L.B.D. 450 Reward
3	Pallet Die No.		15791 (4.0) mm	
4	Die Category	Drg. No.	Je 10	
5	Out Side Diameter	Drg. No.	730 mm Step OD 743.9 mm	Taper 10°
6	Inside Diameter	Drg. No.	630.14 mm	Step length 23.3 / 23.4
7	Width of Pellet Die	Drg. No.	290.6 mm	
8	Grooves as per Drawing	Drg. No.	15.3x8x5 mm / 15.3x8x5 mm	Under cut. 7 mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 0.8 mm Deep Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		685 mm	Tapping No. of holes 16 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 20.5 mm	Tapping Depth 18.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ravi 3/11/25	
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: Ravi 43

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.5 mm	Outside (3-3)		Inner			
3	External Relief Depth		18 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		3	11	25			
	Inspected By (Sign) & Date		Ravi 3/11/25					

Satya 3/11/25

Reviewed by (Engineer-CNC)

Manager-QA