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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. | | 15034 | 50/66 |
| 2 | Machined By | | V.T.L M/c Shop | 55/66 |
| 3 | Pallet Die No. | | 15155 (8.0) mm | Drg No. 1.8.0-32 Rev 08 |
| 4 | Die Category | Drg. No. | N. Tomiba | |
| 5 | Out Side Diameter | Drg. No. | 680.1 mm Step OD. 693 mm | Tapper 8 |
| 6 | Inside Diameter | Drg. No. | 546.12 mm (Bor. 548.2 mm) | Step length 31 mm |
| 7 | Width of Pellet Die | Drg. No. | 195 mm | Undercut. 2.8 mm |
| 8 | Grooves as per Drawing | Drg. No. | 32 x 7 x 9.2 mm / 32 x 7 x 9.1 mm | (4 x 8) mm |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | Face Side Step 2 mm Both Side |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | M/c Shop | |
| 12 | Tapping PCD | | 619 mm | Tapping M16 of Holes 2 Both Side |
| 13 | Tapping Hole Diameter | | M16, Check by M16 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth. 33.4 mm | Tapping Depth. 31.8 mm |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | ok | |
| | Inspected By (Sign) & Date | | Ravi 30/5/25 | |
| 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° Ravi |
| 2 | External Relief Dia | 9.0 mm | Ist Pad | IInd Pad | | | |
| 3 | External Relief Depth | | 16 mm | 11 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 | | 30 | 5 | 25 | | |
| | Inspected By (Sign) & Date | | Ravi 30/5/25 | | | | |

30/5/25

Reviewed by (Engineer-CNC)

Manager-QA