



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.		13389	40/50
2	Machined By		V.T.L. n/c Shop	Drg No. 1.2.09780
3	Pallet Die No.		13409 (3.5) n/c	Revised
4	Die Category	Drg. No.	Extrusion die	
5	Out Side Diameter	Drg. No.	6.20 n/c, Step 002	Tabber 12" Step length 18.5
6	Inside Diameter	Drg. No.	5.20.12 n/c	
7	Width of Pellet Die	Drg. No.	22.2 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No of Holes - 12 Both Side
12	Tapping PCD		56.5 n/c	
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 = 20.4 n/c	Tapping Depth = 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/11/24

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

Count etc = 60

1	Counter Sinking Depth & Finish	OK								Ravi = 35
2	External Relief Dia	4.0 n/c	Outside (3-3)		Inner					
3	External Relief Depth		17 n/c		10 n/c					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Porvace
6	Material Sent For Hardening On Date		28		11		24			

Inspected By (Sign) & Date

Ravi 28/11/24

Reviewed by (Engineer-CNC)
S. 29/11/24

Manager-QA