



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.		13477	45/50
2	Machined By		V. T. G. H/c. Shop	Dry No. 1.20 9930
3	Pallet Die No.		13008 (6.0) H/c	Rev. 2.00
4	Die Category	Drg. No.	Extrusion die	
5	Out Side Diameter	Drg. No.	620 H/c. Step 02. Tapper 12°	
6	Inside Diameter	Drg. No.	520.12 H/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	1348 x 5 H/c 1348 x 5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c. Shop	Tapping No. of Holes = 12 Rohu Side
12	Tapping PCD		565 H/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 = 20.3 H/c. Tapping Depth = 18.6	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date: Ravi 9/12/24

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

1	Counter Sinking Depth & Finish	OK					Counters 60° Ravi 23
2	External Relief Dia	6.5 H/c	Outside (3-3)	Inner			
3	External Relief Depth		1 H/c	5 H/c			

4	Inspection Done Before Hardening By (Name)		Ravi			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		9	12	24	

Inspected By (Sign) & Date: Ravi 9/12/24

Reviewed by (Engineer-CNC): Satish 10/12/24

Manager-QA