

9357



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.		14393 ✓	40/55 ✓
2	Machined By		V. T. L. n/c Shop	Drg No. 132.01143934
3	Pallet Die No.		13468 (B.5) n/c	Rev. 00 ✓
4	Die Category	Drg. No.	Extruder die	
5	Out Side Diameter	Drg. No.	629.8 n/c Step 001 611.8 n/c	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c ✓	
8	Grooves as per Drawing	Drg. No.	1348x5 n/c 1348x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Holes of holes 12 Rota Side
12	Tapping PCD		565 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 20.2 n/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Res: 11/3/25

1	As per programme no.		ok	
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No - 2 hole Colused	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.0 n/c	Outside (3-3)		Inner			
3	External Relief Depth		22 n/c		15 n/c			
4	Inspection Done Before Hardening By (Name)							Res
5	Material Sent For Hardening By (Name)							Lank Porcel
6	Material Sent For Hardening On Date		11	03	25			

Inspected By (Sign) & Date

Res: 11/3/25

Sat 11/3/25

Reviewed by (Engineer-CNC)

Manager-QA