

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Inprocess Inspection (Pellet Dies)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

9443

Check Parameter	Specification	Observations	Remarks
1 Work Order No.		14385	45/50
2 Machined By		V.T.L. n/a Shop	Dr H. S. 1.9.0.9980
3 Pallet Die No.		14385 (6.0) mm	Rev. 100
4 Die Category	Drg. No.	Extruder	
5 Out Side Diameter	Drg. No.	820mm Step 12	
6 Inside Diameter	Drg. No.	520.12 mm	Step length 18.5
7 Width of Pellet Die	Drg. No.	222 mm	
8 Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9 Fitting Sizes on CNC Plate	Drg. No.	ok	
10 Drilling Area Surface Smoothness		ok	
11 Tapping Operator		n/a Shop	Tapping H. of holes 12
12 Tapping PCD		565 mm	Both Side
13 Tapping Hole Diameter		M20 Check by H20 Bolt	
14 Tapping On Second Side	Half pitch of 1st side	ok	
15 Tapping Hole Depth		Drill Depth 20.2 mm Tapping Depth 18.6	
16 Perpendicularity of Tapped Hole		yes	
17 Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date		Ravi 22/3/25	
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 - 14.12. Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker			
1 Counter Sinking Depth & Finish	OK		Counter-Bo
2 External Relief Dia	6.5 mm	Outside 13-25	Inner
3 External Relief Depth		1 mm	5 mm
4 Inspection Done Before Hardening By (Name)		Ravi	
5 Material Sent For Hardening By (Name)		Lark Ramare	
6 Material Sent For Hardening On Date		22 3 25	
Inspected By (Sign) & Date		Ravi 22/3/25	

Reviewed by (Engineer-CNC)

Manager-QA