



Lark Engineering Company (India) Pvt. Ltd.

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

9656

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.		14731	52/55
2	Machined By		V.T.L. H/c Shop	Drg. No. 1.2.21/934
3	Pallet Die No.		13594 (B.5) H/c	Rev. No.
4	Die Category	Drg. No.	Extruder	
5	Out Side Diameter	Drg. No.	630 H/c	Step 00: 611.9 H/c
6	Inside Diameter	Drg. No.	520.12 H/c	Step length: 19.5
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 H/c	Tapping Depth: 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sai: 18/4/25	
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: 60°
2	External Relief Dia	4.0 H/c	Outside (3.3)	Row: 35
3	External Relief Depth		10 H/c	Inner 3 H/c
4	Inspection Done Before Hardening By (Name)		Sai	
5	Material Sent For Hardening By (Name)		Lark Pox nace	
6	Material Sent For Hardening On Date		18	4
Inspected By (Sign) & Date			Sai 18/4/25	

Reviewed by (Engineer-CNC)

Manager-QA