



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)

9742

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14835	48/50/8355
2	Machined By		V.T.L. H/c Shop	(Dry H/c Lark 8355)
3	Pallet Die No.		14645 (3.0) H/c	
4	Die Category	Drg. No.	Extruder	
5	Out Side Diameter	Drg. No.	619.8 H/c, Step 00, 811.8 H/c	Step length 9.5
6	Inside Diameter	Drg. No.	520.12 H/c (1 Bar. Tapping 0.3) H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 H/c 13 x 8 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 H/c
12	Tapping PCD		565 H/c	of 4.1 x 12
13	Tapping Hole Diameter		H202 Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 2.4 H/c Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/4/25

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

Counter 60

1	Counter Sinking Depth & Finish	OK						Row 28
2	External Relief Dia	3.5 H/c	Outside (3-2)		Inner			
3	External Relief Depth		14 H/c		8 H/c			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Porrore			
6	Material Sent For Hardening On Date		28	4	25			

Inspected By (Sign) & Date

Ravi 28/4/25

Reviewed by (Engineer-CNC)

Manager-QA