



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)

9798

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14868 ✓	26/38/53 ✓
2	Machined By		V. T. L. H/C Shop	Dr. H. 18.0.639
3	Pallet Die No.		14046 (5.0) ✓	Revised
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	636 ✓, Step 00, 624 ✓	Tabber 12
6	Inside Diameter	Drg. No.	520.12 ✓	Step length 18 ✓
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 ✓ 13x8x5 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565 ✓	
13	Tapping Hole Diameter		M20 - Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 ✓	Tapping Depth 8.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 6/5/25	
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 20
2	External Relief Dia	5.5 ✓ 6.0 ✓	5.5 ✓ All Rows 2 24 ✓	
3	External Relief Depth		6.0 ✓ All Rows 2 15 ✓	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		6 5 25	
Inspected By (Sign) & Date			Ravi 6/5/25	

Sargu 6/5/25

Reviewed by (Engineer-CNC)

Manager-QA