



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.		14938	29/42
2	Machined By		V.T.L. n/c Shop	Dr. H. (20.15) 431
3	Pallet Die No.		14842 (2.8) n/c	Revised
4	Die Category	Drg. No.	Extrusion die	
5	Out Side Diameter	Drg. No.	614 n/c	Step 00. 611.9 n/c
6	Inside Diameter	Drg. No.	520.14 n/c	Step length 19.5
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		56.5 n/c	Tapping H. of holes 12
14	Tapping On Second Side	Half pitch of 1st side	H20. Check by H20 Bolt	Bolt Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.6 n/c	Tapping Depth 18.6
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Rev: 17/5/25

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 80
2	External Relief Dia	3.3 n/c	outside (3-3)		inner			Row 40
3	External Relief Depth		20 n/c		18 n/c			
4	Inspection Done Before Hardening By (Name)							Rev:
5	Material Sent For Hardening By (Name)							Lark Ruz n/c
6	Material Sent For Hardening On Date		17	5	25			
Inspected By (Sign) & Date								Rev: 17/5/25

Inspected By (Sign) & Date

Rev: 17/5/25

Reviewed by (Engineer-CNC)

Manager-QA