



Lark Engineering Company (India) Pvt. Ltd.

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

9894

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.			
2	Machined By		14931	5316-1
3	Pallet Die No.		V.T.L. H/c Shop	Qty No. 12.0 915
4	Die Category	Drg. No.	13913 (3.8) mm	Rev. 00
5	Out Side Diameter	Drg. No.	Extrude side	
6	Inside Diameter	Drg. No.	64.0 mm Step on G15.5 mm	Tappet 4.0
7	Width of Pellet Die	Drg. No.	52.12 mm	Step length 2.0 mm
8	Grooves as per Drawing	Drg. No.	22.2 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13.8 x 5 mm 13.8 x 5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		56.5 mm	
13	Tapping Hole Diameter		42.0 Check by H/c Bolt	Tapping H/c of Hole 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/5/25

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

Counter B

1	Counter Sinking Depth & Finish	ok							Ravi 33
2	External Relief Dia	4.3 mm	80.8 Side (3.3)		Inner				
3	External Relief Depth		14 mm		7 mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		19	5	25				

Inspected By (Sign) & Date

Ravi 19/5/25

Reviewed by (Engineer-CNC)

Manager-QA