



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.		15060	31/50
2	Machined By		V.T.L. H/c Shop	Dy. No. 1.20.99
3	Pallet Die No.		14613 (3.5) H/c	Rev. No.
4	Die Category	Drg. No.	Extruder	
5	Out Side Diameter	Drg. No.	619.9 H/c	Step 00. Tapper. 12°
6	Inside Diameter	Drg. No.	520.14 H/c	Step length. 18.5
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x2x5 H/c	13x8x5 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 Holes. 12
13	Tapping Hole Diameter		H20. Check by H20 Bolt	Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth. 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/5/25

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 B0
2	External Relief Dia	4.0 H/c	23-35	Inner				Rev. B5
3	External Relief Depth		22 H/c	29 H/c				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		23	5	25			

Inspected By (Sign) & Date

Ravi 23/5/25

Reviewed by (Engineer-CNC)

Manager-QA