



Lark Engineering Company (India) Pvt. Ltd.

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

9987

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.		15073	55/55
2	Machined By		V.T.L. M/C Shop	Dy. M. L. 20.10.95
3	Pallet Die No.		12394(3.2)mm	Rev. 00
4	Die Category	Drg. No.	Extrusion die	
5	Out Side Diameter	Drg. No.	629.8mm	621.4mm Tapper 12
6	Inside Diameter	Drg. No.	520.14mm	Step length 21.5
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		565mm	Tapping No. of holes 12
13	Tapping Hole Diameter		H202 Check by H20.801	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.5mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 29/5/25

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 - 2 Hole Colused

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5mm	22-side		Inner				
3	External Relief Depth		10mm		Mill				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		29	5	25				

Inspected By (Sign) & Date

Ravi 29/5/25

Signature

Reviewed by (Engineer-CNC)

Manager-QA