



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.		15322	40/50/835
2	Machined By		V.T.L. n/a Shop	Dry run. Lark 9811
3	Pallet Die No.		13590(4.0) n/a	
4	Die Category	Drg. No.	Extruder die	
5	Out Side Diameter	Drg. No.	6.20 n/a Step 002 611.9 n/a Step length 1.9	
6	Inside Diameter	Drg. No.	5.20.14 n/a	
7	Width of Pellet Die	Drg. No.	222 n/a	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 n/a 13 x 8 x 5 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	
12	Tapping PCD		565 n/a	Tapping n/a of holes 12
13	Tapping Hole Diameter		M20.1 Check by M20B-1	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/a	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sasi 23/07/25

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 Bore
Hole 231

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5 n/a	Outside 23-31		Inner		
3	External Relief Depth		14 n/a		10 n/a		
4	Inspection Done Before Hardening By (Name)				Sasi		
5	Material Sent For Hardening By (Name)				Lark Furnace		
6	Material Sent For Hardening On Date		23	6	25		

Inspected By (Sign) & Date

Sasi 23/07/25

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Reviewed by (Engineer-CNC)

Manager-QA