



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)

10284

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15389 ✓	33/50 ✓
2	Machined By		V.T.L. H/c Shop	Dry Run 18.09.98
3	Pallet Die No.		15291 (3.0) H/c	Rev. 1.00
4	Die Category	Drg. No.	Extruder	
5	Out Side Diameter	Drg. No.	619.9 H/c	Step on. Tapper. 12"
6	Inside Diameter	Drg. No.	520.12 H/c	(Bore 519.9 H/c) Step length 18.5
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 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	
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H20 Check by H20 Ball	
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

Rev: 16/7/25

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							
2	External Relief Dia	3.5 H/c	Outside 3.33		Inner				
3	External Relief Depth		23 H/c		17 H/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		16	7	25				

Inspected By (Sign) & Date

Rev: 16/7/25

Reviewed by (Engineer-CNC)

Manager-QA