



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)

10283

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15438	40/55
2	Machined By		V.T.L. H/C Shop	Drill Hole 6.20 4924
3	Pallet Die No.		14052 (3.5)	Revised
4	Die Category	Drg. No.	Extruder	
5	Out Side Diameter	Drg. No.	6.30 mm	Step 00. 611.9 mm Step length 19.5
6	Inside Diameter	Drg. No.	5.20.14 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		56.5 mm	
13	Tapping Hole Diameter		M20, Check by M20 B-12	Tapping H. of Holes 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		OK	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Sasi 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

Counter 60

1	Counter Sinking Depth & Finish	OK						Revised 35
2	External Relief Dia	4.0 mm	30 Side (3.3)		Inner			
3	External Relief Depth	22 mm			15 mm			
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

Sasi 16/7/25

Reviewed by (Engineer-CNC)

Manager-QA