



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.		15436	31150
2	Machined By		V. T. L. H/c Shop	Dr. No. 15018
3	Pallet Die No.		15018 (2.8) H/c	Rev. 00
4	Die Category	Drg. No.	Extrude	
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.	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	Tapping No. of holes 2
12	Tapping PCD		565 H/c	Both Side
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 8/8/25	
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. Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter G. 2
2	External Relief Dia	3.3 H/c	Outside 3-3	Row 240
3	External Relief Depth		25 H/c	19 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porvare	
6	Material Sent For Hardening On Date		8 8 25	
Inspected By (Sign) & Date			Ravi 8/8/25	

Reviewed by (Engineer-CNC)

Manager-QA