



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)

10869

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13239	44/50
2	Machined By		V. T. L. N/A Shop	Drg. No. 1209980
3	Pallet Die No.		15834 (4.0) mm	Rev. 00
4	Die Category	Drg. No.	Extruder	
5	Out Side Diameter	Drg. No.	619.9 mm	Step 00
6	Inside Diameter	Drg. No.	520.14 mm	Tapping 12"
7	Width of Pellet Die	Drg. No.	222 mm	Step length 18.5
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 mm / 13 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	
12	Tapping PCD		56.5 mm	Tapping Holes of holes 12
13	Tapping Hole Diameter		H2, Check by H2 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 13/10/25

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 - 1 Hole Closed

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	4.5 mm	Outside (3-3)		Inner				
3	External Relief Depth		14 mm		6 mm				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Pornerce				
6	Material Sent For Hardening On Date		13	10	25				

Inspected By (Sign) & Date

Ravi 13/10/25

Reviewed by (Engineer-CNC)

Manager-QA