



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10929

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.		16405	62/45
2	Machined By		V.T.L. n/a Shop	Drg. No. 18.0.13.2
3	Pallet Die No.		15849(4.0)mm	Rev. 100
4	Die Category	Drg. No.	Extruder	
5	Out Side Diameter	Drg. No.	610mm Step 02. 619mm	Tapper. 10.5
6	Inside Diameter	Drg. No.	520.14mm	Step length 18.5
7	Width of Pellet Die	Drg. No.	222mm	Order cut 4.5mm
8	Grooves as per Drawing	Drg. No.	14x8x5mm / 14x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	Tapping n/a
12	Tapping PCD		565mm	of holes 12
13	Tapping Hole Diameter		420, Check by 420 Bolt	VR Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 11/12/25	
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		Counter. G
2	External Relief Dia	4.5mm	Outside 23-35	Lower 31
3	External Relief Depth		11mm	Inner 3mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ponnare	
6	Material Sent For Hardening On Date		1 11 25	
Inspected By (Sign) & Date			Ravi 11/12/25	

Reviewed by (Engineer-CNC)

Manager-QA