



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9904 ✓	48/50
2	Machined By		N.T.L. n/c Shop	Dry No. Lark ⁶³⁵⁵ 9510
3	Pallet Die No.		10622 (4.0) ✓	
4	Die Category	Drg. No.	Extruder	
5	Out Side Diameter	Drg. No.	619.8 ✓ Step OD, 611.9 ✓ Step length	194
6	Inside Diameter	Drg. No.	520.12 ✓	
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 ✓ / 13x8x5 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	[Tapping No. of Holes = 12 Both Side]
12	Tapping PCD		585 ✓	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 ✓ Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/7/23

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									Ravi 31
2	External Relief Dia	4.5 ✓	Outside (3-3)		Inner						
3	External Relief Depth	—	10 ✓		2 ✓						
4	Inspection Done Before Hardening By (Name)				Ravi						
5	Material Sent For Hardening By (Name)				Lark Furnace						
6	Material Sent For Hardening On Date		15	7	23						

Inspected By (Sign) & Date

Ravi 15/7/23

Reviewed by (Engineer-CNC)

Manager-QA