



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.		11461 ✓	45/55
2	Machined By		V.T.L. H/c Shop	Drg No. = I.E.C. 14951
3	Pallet Die No.		11943 (G.O) H/H	Rev. = 00
4	Die Category	Drg. No.	Extrusion die	
5	Out Side Diameter	Drg. No.	6.30mm, Step 00: 6.21.5mm, Tapper. 12	
6	Inside Diameter	Drg. No.	5.20.14mm	Step length = 21.5mm
7	Width of Pellet Die	Drg. No.	22.2mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
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 = 12 Both Side
12	Tapping PCD		56.5mm	
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 = 20.7mm Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/3/24

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 = 60° Ravi 19/3/24
2	External Relief Dia	6.5mm	outside (3-3)		inner			
3	External Relief Depth		16mm		10mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		19	3	24			

Inspected By (Sign) & Date

Ravi 19/3/24

Satish 19/3/24

Reviewed by (Engineer-CNC)

Manager-QA