



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

5598

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9651	28/45
2	Machined By		V.T.L H/C Shop	Drg No. L-S-D-597
3	Pallet Die No.		9935 (3.0)	Rev = 00
4	Die Category	Drg. No.	Extruder die	
5	Out Side Diameter	Drg. No.	610mm	
6	Inside Diameter	Drg. No.	Step 00 = 632.6mm	Tapper = 12°
7	Width of Pellet Die	Drg. No.	520.6mm	Step length = 18mm
8	Grooves as per Drawing	Drg. No.	322mm	Under cut = 6.3mm
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5mm / 13x8x5mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/C Shop	Tapping No of holes = 12 Both Side
13	Tapping Hole Diameter		565mm	
14	Tapping On Second Side	Half pitch of 1st side	H20 = Check by H20 Ball	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 20.5mm	Tapping Depth = 18.8mm
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 11/6/23

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 - 1 Hole Colused / A

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	2.3mm	outside (3-3)		Inner			Force 28
3	External Relief Depth	/	24mm		21mm			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							Ravi
6	Material Sent For Hardening On Date							Lark Furnace
				1	6	23		

Inspected By (Sign) & Date

Ravi 11/6/23

viewed by (Engineer-CNC)

Manager-QA