



Lark Engineering Company (India) Pvt. Ltd.

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

10470

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.		15738	50/50
2	Machined By		V. T. L. w/c Shop	Dry Holes
3	Pallet Die No.		15001 (4.0) w/c	
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	619.9 w/c	Step 0.8 mm
6	Inside Diameter	Drg. No.	520.14 w/c	520.3 mm
7	Width of Pellet Die	Drg. No.	222 w/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 w/c	13x8x5 w/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		w/c Shop	
12	Tapping PCD		565 w/c	
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.4 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/8/25

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 - 2 Holes Closed

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

Count 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 mm	8.3 mm	Inner					
3	External Relief Depth		8 mm	Mill					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Furnace					
6	Material Sent For Hardening On Date		13	8	25				

Inspected By (Sign) & Date

Ravi 13/8/25

Saty 13/8/25

Reviewed by (Engineer-CNC)

Manager-QA