



Lark Engineering Company (India) Pvt. Ltd.

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

10566

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.		15860	
2	Machined By		U7h-MIC Sharp	30/40/65
3	Pallet Die No.		15861	60.0 mm / 60.9 mm
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	880.7 mm	OD Step - 693 mm
6	Inside Diameter	Drg. No.	548.1 mm	Step height - 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1	Scrap per 8°
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Undercut - 2.5 mm
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MIC Sharp	2 Ball Both Sides
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		M16	check M16 Bolt
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 33.4 mm	Tapping Depth - 31.6 mm
16	Perpendicularity of Tapped Hole		✓	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

11/9/25

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

Counter - 30°

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	26.5, 27.0	6.5 mm	0.7-0				
3	External Relief Depth	36 mm	26 mm					
4	Inspection Done Before Hardening By (Name)		Sanjiv					
5	Material Sent For Hardening By (Name)		hank					
6	Material Sent For Hardening On Date		1	9	25			

Inspected By (Sign) & Date

11/9/25

Reviewed by (Engineer-CNC)

Manager-QA