



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)

10804

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16117 ✓	40/50 ✓
2	Machined By		UTL m/c Shop	Org. Lark Shop ✓
3	Pallet Die No.		15400 (3.0) mm	
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620 mm	Step 02 612
6	Inside Diameter	Drg. No.	590 mm	Step length 19.5
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping No of Hole - 19
11	Tapping Operator		UTL m/c Shop	Both side
12	Tapping PCD		565	
13	Tapping Hole Diameter		M 20 check by M 20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 20.5 Tapping depth 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Mahegh 6/10/25

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

1	Counter Sinking Depth & Finish	OK					Counter 60°
2	External Relief Dia	3.5 mm	outer (3-3)		Inner		Row -
3	External Relief Depth		16.4 mm		105 mm		
4	Inspection Done Before Hardening By (Name)		Mahegh				
5	Material Sent For Hardening By (Name)		Lark furnace				
6	Material Sent For Hardening On Date		6	10	25		

Inspected By (Sign) & Date

Mahegh 6/10/25

Reviewed by (Engineer-CNC)

Manager-QA