

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)

10811

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16045	40/50
2	Machined By		UTL-M/c Shop	Page No 150 493
3	Pallet Die No.		14579 (4.0) mm	(Rev)
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	200 mm	Step length 90 mm
6	Inside Diameter	Drg. No.	600 mm	Step 90 643 mm
7	Width of Pellet Die	Drg. No.	292 mm	
8	Grooves as per Drawing	Drg. No.	125x10x75 mm	Tapping No of
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Male - 12
10	Drilling Area Surface Smoothness		OK	Both Side
11	Tapping Operator		M/c Shop	
12	Tapping PCD		640 mm	
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 20.5 mm Tapping Depth 18.5 mm	
16	Perpendicularity of Tapped Hole		YES	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Mahesh 7/10/25

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	4.5 mm	outer (3.5)		Inner		Row 31
3	External Relief Depth		14.5		10.5 mm		
4	Inspection Done Before Hardening By (Name)		Mahesh				
5	Material Sent For Hardening By (Name)		Lark furnace				
6	Material Sent For Hardening On Date		7	10	25		
Inspected By (Sign) & Date		Mahesh 7/10/25					

Reviewed by (Engineer-CNC)

Manager-QA