



Lark Engineering Company (India) Pvt. Ltd.

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

10806

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.		16094 ✓	30/50
2	Machined By		UTL- m/c Shop	Dryer 6355
3	Pallet Die No.		15692 (8.0) mm	
4	Die Category	Drg. No.	SSW	
5	Out Side Diameter	Drg. No.	62.0 mm	Step op 61.2 mm
6	Inside Diameter	Drg. No.	52.0 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 12
11	Tapping Operator		m/c Shop	Both Side ✓
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 Chuck By M20 Bolt	
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

Makeish 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 ✓	outer (3.3)		inner			Row - 38
3	External Relief Depth		235		20.5			
4	Inspection Done Before Hardening By (Name)		Makeish					
5	Material Sent For Hardening By (Name)		Lark Finance					
6	Material Sent For Hardening On Date		06	10	25			

Inspected By (Sign) & Date

6/10/25

Reviewed by (Engineer-CNC)

Manager-QA