



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 (Pollet Dies)

10812

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16195	33/40
2	Machined By		UTL M/c Shop	
3	Pallet Die No.		15671 (3.0) mm	Page No - 15062 (A200)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm	
6	Inside Diameter	Drg. No.	Step 00 498.8 mm	
7	Width of Pellet Die	Drg. No.	420 mm	Step Length 18 mm
8	Grooves as per Drawing	Drg. No.	158 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12 X 8 X 3 mm	Tapping No of
10	Drilling Area Surface Smoothness		OK	Hole 8
11	Tapping Operator		M/c shop	Both side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20 locking by m20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.5 Tapping Depth 18 mm	
16	Perpendicularity of Tapped Hole		X23	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Makeh 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	3-5 mm	outer 2-2	inner			Row 24
3	External Relief Depth		13.6	7 mm			
4	Inspection Done Before Hardening By (Name)		Makeh				
5	Material Sent For Hardening By (Name)		Lark Furnence				
6	Material Sent For Hardening On Date		7	10	25		

Inspected By (Sign) & Date

Makeh 7-10-25

Reviewed by (Engineer-CNC)

Manager-QA