



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)

10807

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16180 ✓	42/50 ✓
2	Machined By		UTH M/C Shop	Part No 430 406 A 100
3	Pallet Die No.		15831 (6.0) mm ✓	
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620 mm Stepped 624mm ✓	
6	Inside Diameter	Drg. No.	520 mm ✓	Step length 18 mm
7	Width of Pellet Die	Drg. No.	292 mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No of
10	Drilling Area Surface Smoothness		OK	Hole 12
11	Tapping Operator		M/C Shop	Both side ✓
12	Tapping PCD		565 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 Tapping depth 18.5 ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Makegh 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	6.5 mm	other 3-5		Inner		Row-23
3	External Relief Depth	✓	14 mm	✓	8.5 mm	✓	
4	Inspection Done Before Hardening By (Name)		Makegh				
5	Material Sent For Hardening By (Name)		Lark Furnace Co				
6	Material Sent For Hardening On Date		6	10	25		

Inspected By (Sign) & Date

Makegh 6/10/25

Reviewed by (Engineer-CNC)

Manager-QA