



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16145	30/66
2	Machined By		VTL m/c Shop	Qty no 120 350
3	Pallet Die No.		16266 (6.0) mm	(2008)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 mm	Step OD 693.1 mm
6	Inside Diameter	Drg. No.	546 mm	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	
8	Grooves as per Drawing	Drg. No.	37x7x4x9.1 mm	Tapping No of
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Male & Both side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		m/c Shop	Free cut with gun
12	Tapping PCD		619 mm	Both side
13	Tapping Hole Diameter		M16 check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.5 Tapping Depth 31.5	
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						Center 30°
2	External Relief Dia	7 mm	Outer		Inner			Row 6-6
3	External Relief Depth		36.5		36.5			
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

Reviewed by (Engineer-CNC)

Manager-QA