



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)

10815

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16098	38/50
2	Machined By		UTL m/c shop	Qty 10 LSP 452
3	Pallet Die No.		15533 (4.0)mm	(Perov)
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	520 mm Step 00 491 mm	
6	Inside Diameter	Drg. No.	420 mm	Step length 16 S
7	Width of Pellet Die	Drg. No.	173 mm	
8	Grooves as per Drawing	Drg. No.	10x 8.5x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping Hoof
10	Drilling Area Surface Smoothness		OK	Hole 8.
11	Tapping Operator		m/s Shop	Both side
12	Tapping PCD		455 mm	
13	Tapping Hole Diameter		Ø 3/4" checking by Ø 3/4" Bdt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 20.5 Tapping depth 18.5 mm	
16	Perpendicularity of Tapped Hole		✓ 18	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

maresh 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 (2-2)	Inner			Row 24
3	External Relief Depth		16.6 mm	12.4 mm			
4	Inspection Done Before Hardening By (Name)		maresh				
5	Material Sent For Hardening By (Name)		Lark furnace				
6	Material Sent For Hardening On Date		7	10	25		
Inspected By (Sign) & Date		maresh 7/10/25					

Reviewed by (Engineer-CNC)

Manager-QA