

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)

10820

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16241	19/86
2	Machined By		UTL m/c shop	Drg No 609 (Reo)
3	Pallet Die No.		16462 (6.0) mm	
4	Die Category	Drg. No.	M-5060	
5	Out Side Diameter	Drg. No.	680.69 mm	Step o.d 643mm
6	Inside Diameter	Drg. No.	546 mm	Step length 31mm
7	Width of Pellet Die	Drg. No.	145 mm	
8	Grooves as per Drawing	Drg. No.	32x7x4x9.2 mm	Tapping No. of
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Hole 2
10	Drilling Area Surface Smoothness		OK	Both side
11	Tapping Operator		m/c shop	
12	Tapping PCD		619 mm	face groove 2mm
13	Tapping Hole Diameter		m16 check by m16	both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 33.5 mm	Tapping Depth 215
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Mahesh 8/10/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		Yes

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK					Counter 30°
2	External Relief Dia	7.5 mm	outer		inner		
3	External Relief Depth		47 mm		47 mm		
4	Inspection Done Before Hardening By (Name)		Mahesh				
5	Material Sent For Hardening By (Name)		hark furnace				
6	Material Sent For Hardening On Date		8	10	25		

Inspected By (Sign) & Date

Mahesh 8/10/25

Reviewed by (Engineer-CNC)

Manager-QA