

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10823

Form No. CNC/QA/FM/02

Rev. No. 01

Rev. Date 31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16198	36/84/78
2	Machined By		UTL m/c shop	Page no 1325 (Rev)
3	Pallet Die No.		15373 (6.5) mm	
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	636 mm	Step 02 630.5/543 mm
6	Inside Diameter	Drg. No.	475 mm	Step length 26/16.5
7	Width of Pellet Die	Drg. No.	182 mm	2nd step length 23 mm
8	Grooves as per Drawing	Drg. No.	27x12x8x9.5 / 37x12x8x9.5	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Taping No of
10	Drilling Area Surface Smoothness		OK	Hole 4
11	Tapping Operator		m/c shop	Both side
12	Tapping PCD		540 mm	
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 28.5 mm Tapping depth 26.5 mm	
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)		NO

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	outer 7 mm		inner 9.5 mm			Row 9
3	External Relief Depth	12.5 mm		14.8 mm			
4	Inspection Done Before Hardening By (Name)		Mahesh				
5	Material Sent For Hardening By (Name)		Lark Fournence				
6	Material Sent For Hardening On Date		8	10	25		

Inspected By (Sign) & Date

Mahesh 8/10/25

Reviewed by (Engineer-CNC)

Manager-QA