



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)

5947

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10296	
2	Machined By		U76 MIC Shop	36/S1
3	Pallet Die No.		10773 (3.0m)	Drg No 537 Rev 00
4	Die Category	Drg. No.	Midumbo	
5	Out Side Diameter	Drg. No.	732 mm OD Step 743 mm	Step length 27.5 mm
6	Inside Diameter	Drg. No.	630 mm	
7	Width of Pellet Die	Drg. No.	255 mm	under cut = 5.9 mm
8	Grooves as per Drawing	Drg. No.	22x8x7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping Holes - 12 Body
11	Tapping Operator		MIC Shop	(Side)
12	Tapping PCD		685 mm	
13	Tapping Hole Diameter		M22 (check M22 Bolt)	Tapper 4°
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth 26.5 mm	Tapping Depth - 26.7 mm
16	Perpendicularity of Tapped Hole		YU	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Sanjeev 14/8/23

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

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

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	Ø 3-5	outside	MIN 14			
3	External Relief Depth		21 mm (Ø-3)	15 mm			
4	Inspection Done Before Hardening By (Name)		Sanjeev				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		14	8	23		

Inspected By (Sign) & Date

Sanjeev 14/8/23

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Reviewed by (Engineer-CNC)

Manager-QA