



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13202	
2	Machined By		VTL-MIC Shop	60/60
3	Pallet Die No.		12855 (5.0) mm	Drg. No. - 4B Rev
4	Die Category	Drg. No.	M. dumb	
5	Out Side Diameter	Drg. No.	720 mm OD Step - 693 mm	Step height - 20 mm
6	Inside Diameter	Drg. No.	600 mm	
7	Width of Pellet Die	Drg. No.	222 mm	Tapper 12°
8	Grooves as per Drawing	Drg. No.	1 1/2 x 8 x 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Tapping Moab
11	Tapping Operator		MIC Shop	Holes - 12 Both
12	Tapping PCD		640 mm	
13	Tapping Hole Diameter		M20 Check M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drilling Depth - 22.3 mm	Tapping Depth - 20.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Jan 13/11/24

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

County - 80

1	Counter Sinking Depth & Finish	ok							Row-26
2	External Relief Dia	0.5 mm	outside	4MM24					
3	External Relief Depth	5 mm	3-8	M12L					
4	Inspection Done Before Hardening By (Name)		Sanjay						
5	Material Sent For Hardening By (Name)		work peraw						
6	Material Sent For Hardening On Date		13	11	24				

Inspected By (Sign) & Date

Jan 13/11/24

Reviewed by (Engineer-CNC)

Manager-QA