



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)

8491

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13206 ✓	38150 ✓
2	Machined By		MIC Sharp	
3	Pallet Die No.		13379 (3.0m) ✓	Drilling 3880 ✓
4	Die Category	Drg. No.	SSCW	
5	Out Side Diameter	Drg. No.	620 mm, Tappan 12°	Step length - 18 ✓
6	Inside Diameter	Drg. No.	520 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping Mark ✓
10	Drilling Area Surface Smoothness		ok	Holes - 12 ✓
11	Tapping Operator		MIC Sharp	
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 check by M20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drilling Depth - 20 mm Tapping Depth - 18.5 mm ✓	
16	Perpendicularity of Tapped Hole		✓	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Jagjit

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				
2	External Relief Dia	3.5 mm	outer 3-3	4 mm ✓		
3	External Relief Depth		18 mm ✓	12 mm ✓		
4	Inspection Done Before Hardening By (Name)		<i>Sagjit</i>			
5	Material Sent For Hardening By (Name)		<i>hark for me</i>			
6	Material Sent For Hardening On Date		7	11	24	

Inspected By (Sign) & Date

Jagjit 31/11/24

Reviewed by (Engineer-CNC)

Manager-QA