



Lark Engineering Company (India) Pvt. Ltd.

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

8496

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.		13208	
2	Machined By		U.T.L MIC Shop	50150
3	Pallet Die No.		13440 (6.0)	Drum 415 P.01
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 mm, O.D Step- 499 mm	Step length 20 mm
6	Inside Diameter	Drg. No.	420 mm	Flap 127
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MIC Shop	Tapping No of Holes = 8
12	Tapping PCD		454 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- 18.3 mm Tapping Depth- 16.0 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Jayew 8/11/24

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

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	φ 6.3	outside	1.1 mm		
3	External Relief Depth		4 mm (R-2)	0		
4	Inspection Done Before Hardening By (Name)		Sanjeev			
5	Material Sent For Hardening By (Name)		work	formus		
6	Material Sent For Hardening On Date		8	4	24	

Inspected By (Sign) & Date

Jayew 8/11/24

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Reviewed by (Engineer-CNC)

Manager-QA