



# 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.		13171	35/63/78
2	Machined By		V76 MIC Shop	
3	Pallet Die No.		13617 (60)mm	Drum 396 Ro2
4	Die Category	Drg. No.	M. 84mpo	
5	Out Side Diameter	Drg. No.	636 mm	OD Step: 632, 543, 630.5mm
6	Inside Diameter	Drg. No.	500, 489mm	OD Step: 17, 26mm
7	Width of Pellet Die	Drg. No.	182 mm	
8	Grooves as per Drawing	Drg. No.	12x8x9.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	one slot = 28x17mm
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MIC Shop	Tapping Hoaf
12	Tapping PCD		540 mm	Holes - 4 one slot
13	Tapping Hole Diameter		M16 Check M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Dep. - 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

Jan Jan 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	Ø6.5	Ø6.5	Ø7.0			
3	External Relief Depth		43mm	All	15mm	NO	
4	Inspection Done Before Hardening By (Name)		Sanjay				
5	Material Sent For Hardening By (Name)		Work from				
6	Material Sent For Hardening On Date		8	11	24		

### Inspected By (Sign) & Date

Jan Jan 8/11/24

Reviewed by (Engineer-CNC)

Manager-QA