



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.		13135 ✓	
2	Machined By		U7L MIC Shop	45/60 ✓
3	Pallet Die No.		13295 (8.0) mm ✓	Drilling H- 1194 Rev ✓
4	Die Category	Drg. No.	M. Sumbho	
5	Out Side Diameter	Drg. No.	7.20 mm, OD Step-693	Step height-19.7 ✓
6	Inside Diameter	Drg. No.	6.00 mm ✓	Upper 12' ✓
7	Width of Pellet Die	Drg. No.	222 mm ✓	
8	Grooves as per Drawing	Drg. No.	12x8x5 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	
10	Drilling Area Surface Smoothness		ok ✓	Tapping H.O. of head - 12 Both Sides ✓
11	Tapping Operator		MIC Shop	
12	Tapping PCD		840 mm ✓	
13	Tapping Hole Diameter		M20 Check M20 Belt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok ✓	
15	Tapping Hole Depth		Drilling Depth 20mm Tapping Depth - 18.5 ✓	
16	Perpendicularity of Tapped Hole		yes ✓	
17	Visual Inspection Before Gun Drilling		ok ✓	

Inspected By (Sign) & Date

Jangir 12/11/24

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

Counts 60-

1	Counter Sinking Depth & Finish	ok ✓								Row-18
2	External Relief Dia	Ø85	outside	stamped						
3	External Relief Depth	✓	25 mm	(3-3)	15 mm					
4	Inspection Done Before Hardening By (Name)		C. Jangir							
5	Material Sent For Hardening By (Name)		12/11/24							
6	Material Sent For Hardening On Date		12	11	24					

Inspected By (Sign) & Date

Jangir

Reviewed by (Engineer-CNC)

Manager-QA