



# 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.		13184	
2	Machined By		U7K - MIC Shop	42/66 ✓
3	Pallet Die No.		13625 (8.0) mm	Length 788 mm ✓
4	Die Category	Drg. No.	M. Jambor	
5	Out Side Diameter	Drg. No.	678 mm	OD Step - 693 mm
6	Inside Diameter	Drg. No.	546.1 mm	215 Step height - 38 mm
7	Width of Pellet Die	Drg. No.	195 mm	Tapper 8° ✓
8	Grooves as per Drawing	Drg. No.	31 x 8 x 9 mm	Undercut = 2.9 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MIC Shop	
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		OK	
14	Tapping On Second Side	Half pitch of 1st side	OK	MIG check by MIG Belt face - 42 x 2u
15	Tapping Hole Depth		Drilling Depth - 39.3 mm	Tapping Depth - 36.5 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Jan Jan 16/11/24

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								Row 12
2	External Relief Dia	07-0	24 mm	24 mm						
3	External Relief Depth									
4	Inspection Done Before Hardening By (Name)		Sample							
5	Material Sent For Hardening By (Name)		hok	from						
6	Material Sent For Hardening On Date		12	11	24					

### Inspected By (Sign) & Date

Jan Jan 16/11/24

Reviewed by (Engineer-CNC)

Manager-QA