



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.		13246	
2	Machined By		U7L MIC Shop	47/50
3	Pallet Die No.		13172 (8.0) mm	Drill 254 dia
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	520 mm	OD step - 491 mm
6	Inside Diameter	Drg. No.	420 mm	step length - 17 mm
7	Width of Pellet Die	Drg. No.	182 mm	
8	Grooves as per Drawing	Drg. No.	10x10x5 mm	(Tapping Hole)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	(Holes - 8)
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MIC Shop	
12	Tapping PCD		475 mm	
13	Tapping Hole Diameter		Ø 3/16" Check by Ø 3/16" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 19.2 mm Tapping Depth - 17.5 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Jain 20/11/24

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				
2	External Relief Dia	Ø 8.5	outside	2MM/4P		
3	External Relief Depth		13mm (2-2)	5mm		
4	Inspection Done Before Hardening By (Name)		Sanjiv			
5	Material Sent For Hardening By (Name)		hote furu			
6	Material Sent For Hardening On Date		20	11	24	

Inspected By (Sign) & Date

Jain 20/11/24

Sanjiv 20/11/24

Reviewed by (Engineer-CNC)

Manager-QA