



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)

8590

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13273	
2	Machined By		V72 MIC Shap	38150
3	Pallet Die No.		13447 (4.0)mm	Drill H- 322 Po
4	Die Category	Drg. No.	Sender	
5	Out Side Diameter	Drg. No.	520 mm, OD Step - 500 mm	Step height - 18mm
6	Inside Diameter	Drg. No.	420 mm	
7	Width of Pellet Die	Drg. No.	158 mm	Top for 10°
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 Shap	Tapping Mark Hole - 8
12	Tapping PCD		455 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 mm Tapping Depth - 18 mm	
16	Perpendicularity of Tapped Hole		OK	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Janjan 13/11/24

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	Ø 4.5	outside	INNER			
3	External Relief Depth		16 mm (2mm)	12 mm			
4	Inspection Done Before Hardening By (Name)		Sanjan				
5	Material Sent For Hardening By (Name)		Wark Purus				
6	Material Sent For Hardening On Date		13	11	24		

Inspected By (Sign) & Date

Janjan 13/11/24

13/11/24

Reviewed by (Engineer-CNC)

Manager-QA