



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.		13193	
2	Machined By		U7K - MIC Shop	5/66
3	Pallet Die No.		13631 (8.0)mm	Drng No - 320 Prod
4	Die Category	Drng. No.	M. Jumbo	
5	Out Side Diameter	Drng. No.	680.1mm, OD Step - 693mm	Step length - 31mm
6	Inside Diameter	Drng. No.	546.1mm	
7	Width of Pellet Die	Drng. No.	195mm	Tappin 8°
8	Grooves as per Drawing	Drng. No.	32 x 7 x 3mm (center - 4 x 8)	
9	Fitting Sizes on CNC Plate	Drng. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping No of
11	Tapping Operator		MIC Shop	Hole & Both side
12	Tapping PCD		619mm	
13	Tapping Hole Diameter		M16 Check M16 Bolt	(Pa - 45 x 2mm)
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 33mm	Tapping Depth - 31.5mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Jayraj 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

Counter - 30°

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	Ø 9.0	Outside	1mm						
3	External Relief Depth		11mm	All	11mm	All				
4	Inspection Done Before Hardening By (Name)		Sanjay							
5	Material Sent For Hardening By (Name)		Werk	for us						
6	Material Sent For Hardening On Date		12	8	24					

Inspected By (Sign) & Date

Jayraj 12/11/24

Satya 12/11/24

Reviewed by (Engineer-CNC)

Manager-QA