



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.		13222 ✓	
2	Machined By		VTK MIC Shap	40150
3	Pallet Die No.		13444 (4.0) mm	Drilling - 21 Per cent
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 mm OD Step 499 mm	Step height - 17mm
6	Inside Diameter	Drg. No.	420.1 mm	
7	Width of Pellet Die	Drg. No.	158 mm	Tappers 12'
8	Grooves as per Drawing	Drg. No.	12 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		MIC Shap	Tapping Ho of Hols - 8 both side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		Ø 3/4" Check Ø 3/4" Belt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drilling Depth - 22 mm Tapping Depth - 19.5 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Jan 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

Country - 60

Raw - 20

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	Ø 4.5	outside	4MMK			
3	External Relief Depth		14mm (2-2)	10mm			
4	Inspection Done Before Hardening By (Name)		Sanjay				
5	Material Sent For Hardening By (Name)		work Purcar				
6	Material Sent For Hardening On Date		12	11	25		

Inspected By (Sign) & Date

Jan 12/11/24

Reviewed by (Engineer-CNC)

Manager-QA