



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8537

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.			
2	Machined By		13212	
3	Pallet Die No.		U7L - MIC Shop	3042
4	Die Category	Drg. No.	13545 (4.0) mm	Drg. M 1178 Rev 0
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	399 mm, OD Step - 388 mm	Step Length - 3.3 mm
7	Width of Pellet Die	Drg. No.	315 mm	
8	Grooves as per Drawing	Drg. No.	145 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	8x8x3 mm	(Tapping Ho of Holes - 8) Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		MIC Shop	
13	Tapping Hole Diameter		360, 355 mm	
14	Tapping On Second Side	Half pitch of 1st side	OK	check by Ball
15	Tapping Hole Depth		Drilling Depth - 20 mm	Tapping Depth - 18.5 mm
16	Perpendicularity of Tapped Hole		OK	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Sanjeev 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	4.5 mm	outside		4.1 mm	
3	External Relief Depth		16 mm (2-2)		12 mm	
4	Inspection Done Before Hardening By (Name)		Sanjeev			
5	Material Sent For Hardening By (Name)		Lark firm			
6	Material Sent For Hardening On Date		13	11	24	

Inspected By (Sign) & Date

Sanjeev 13/11/24

Sanjeev 31/11/24

Reviewed by (Engineer-CNC)

Manager-QA