



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.		13195	
2	Machined By		U7K - MIC Shop	30/66
3	Pallet Die No.		13632 (6.0) mm	Drilling No 302 Rev 0
4	Die Category	Drg. No.	H. Sumbro	
5	Out Side Diameter	Drg. No.	680 mm OD Step - 693 mm	Step Length - 38.5
6	Inside Diameter	Drg. No.	548.6 mm	
7	Width of Pellet Die	Drg. No.	195 mm	Taper 8.5°
8	Grooves as per Drawing	Drg. No.	26.5 x 10 x 9 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Undercut - 3.3 mm
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		MIC Shop	Tapping Ho of
12	Tapping PCD		619 mm	Field - 2 Bores
13	Tapping Hole Diameter		M16 Check marked by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drilling Depth - 32.5 mm	Tapping Depth - 30.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Jan 16/11/24

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 7.0	outside	All		
3	External Relief Depth	✓	36 mm	All		
4	Inspection Done Before Hardening By (Name)		Sanjiv			
5	Material Sent For Hardening By (Name)		hant per me			
6	Material Sent For Hardening On Date		16	11	24	

Inspected By (Sign) & Date

Sanjiv 16/11/24

16/11/24

Reviewed by (Engineer-CNC)

Manager-QA