



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.			
2	Machined By		13135	
3	Pallet Die No.		UTK MICShop	45/60
4	Die Category	Drg. No.	13296 (8.0) mms	Drg No 1174/10
5	Out Side Diameter	Drg. No.	M. Rumbro	
6	Inside Diameter	Drg. No.	720 mm	OD Step - 693 mm
7	Width of Pellet Die	Drg. No.	600 mm	Step height - 20
8	Grooves as per Drawing	Drg. No.	292 mm	Flapper 12°
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		MIC Shop	Tapping Hoop
12	Tapping PCD		640 mm	Holes - 12 Both
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 - 20.2 mm	Tapping Depth - 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Jay for 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

County - 60°

1	Counter Sinking Depth & Finish	ok																		
2	External Relief Dia	φ 8.5	outside																	
3	External Relief Depth		23 mm (3-3)	15 mm																
4	Inspection Done Before Hardening By (Name)		Sonju																	
5	Material Sent For Hardening By (Name)		hate Ramu																	
6	Material Sent For Hardening On Date		13	11	24															

Inspected By (Sign) & Date

Jay for 13/11/24

Sot 13/11/24

Reviewed by (Engineer-CNC)

Manager-QA