



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		13308 ✓	
3	Pallet Die No.		U7L - MIC Shop	42/170
4	Die Category	Drg. No.	13451 (6-0) ✓	Dry fit 13760/A ✓
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	520 mm, OD Step - 491 mm	Step Length 173
7	Width of Pellet Die	Drg. No.	420 mm ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm, 15d mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 mm	Flapping HO of Hols - & Bottom ✓
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		MIC Shop	
12	Tapping PCD		454 mm ✓	
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 7.5 mm Tapping Depth 16.5 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Jagj 19/11/24

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 - 60

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	2.65	outside	1.1 M20		
3	External Relief Depth	14 mm	(3-3)	8mm		
4	Inspection Done Before Hardening By (Name)	Sanjay				
5	Material Sent For Hardening By (Name)	Nak fernu				
6	Material Sent For Hardening On Date	19	11	24		

Inspected By (Sign) & Date

Jagj 19/11/24

Sanjay 19/11/24
Reviewed by (Engineer-CNC)

Manager-QA