



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.		13330 ✓	
2	Machined By		V71-MIC Shop	36/50/60 ✓
3	Pallet Die No.		13026 (4.0) mm ✓	Drg No - 111 Rev ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 mm OD Step-792 mm	Step length - 265 mm ✓
6	Inside Diameter	Drg. No.	660.1 mm ✓	
7	Width of Pellet Die	Drg. No.	324 mm ✓	Undercut - 6 mm ✓
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	(2 Holes both side 32 x 8 mm) ✓
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MIC Shop	
12	Tapping PCD		725 mm ✓	Tapping No of Holes - 12 Both side ✓
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 - 81.2 mm Tapping Depth - 29.4 mm ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Jan Jan 20/11/24

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

Counts - 60

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	Ø 4.5, Ø 5.0	Ø 4.5 mm	Ø 5.0		
3	External Relief Depth		24 mm All	10 mm All		
4	Inspection Done Before Hardening By (Name)		Sanjay			
5	Material Sent For Hardening By (Name)		Mark Kumar			
6	Material Sent For Hardening On Date		20	11	24	

Inspected By (Sign) & Date

Jan Jan 20/11/24

Sanjay 20/11/24

Reviewed by (Engineer-CNC)

Manager-QA