



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.		13327 ✓	
2	Machined By		V7L MIC Sharp	35/40/66
3	Pallet Die No.		13627 (6.0) mm	Drilling 320 Pcd
4	Die Category	Drg. No.	M-Symbol	
5	Out Side Diameter	Drg. No.	680.1 mm, OD Step - 693 mm	Step height - 31 mm
6	Inside Diameter	Drg. No.	546.2 mm	Chamfer 8°
7	Width of Pellet Die	Drg. No.	195 mm	
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	LSD 320 Rev 01
10	Drilling Area Surface Smoothness		OK	to
11	Tapping Operator		MIC Sharp	LSD-609 Rev 03
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		M16 Check M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 33.2 mm Tapping Depth - 31.5 mm	
16	Perpendicularity of Tapped Hole		OK	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

[Signature] 18/11/24

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 - 30

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	Ø 6.5	ALL	Ø 7.0	ALL		
3	External Relief Depth		3 mm		26 mm		
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		18	11	24		

Inspected By (Sign) & Date

[Signature] 18/11/24

Reviewed by (Engineer-CNC)

Manager-QA