



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.		13329 ✓	
2	Machined By		VTK - MIC Shop	36/46/50
3	Pallet Die No.		13389 (4.0) mm ✓	Dring H - huts
4	Die Category	Drg. No.	SSC10	
5	Out Side Diameter	Drg. No.	620 mm	Step Length - 19.5 mm
6	Inside Diameter	Drg. No.	520 mm	
7	Width of Pellet Die	Drg. No.	292 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	(Flapping No of holes - 12)
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		MIC Shop	
12	Tapping PCD		585 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 - 20.4 mm Tapping Depth - 18.6 mm	
16	Perpendicularity of Tapped Hole		ok	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Jayju 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

Counter 6

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia		Ø4.5		Ø5.0	
3	External Relief Depth	Ø4.5, 5.0	1.6 mm	All	4 mm	ok
4	Inspection Done Before Hardening By (Name)		Banju			
5	Material Sent For Hardening By (Name)		hark kumar			
6	Material Sent For Hardening On Date		20	11	24	

Inspected By (Sign) & Date

Jayju 20/11/24

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Reviewed by (Engineer-CNC)

Manager-QA