



# 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.		13331 ✓	
2	Machined By		V7H-MIC Shop	44/55 ✓ P20
3	Pallet Die No.		13175 (3.5) mm ✓	Drilling 7430/31 ✓
4	Die Category	Drg. No.	44 mm dia	
5	Out Side Diameter	Drg. No.	770 mm	OD step - 793 mm step length - 27 mm
6	Inside Diameter	Drg. No.	660 mm	
7	Width of Pellet Die	Drg. No.	324 mm ✓	Undercut = 11.5 mm
8	Grooves as per Drawing	Drg. No.	2.5 x 8 x 12 mm ✓	(2.8 bit Both side)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	32 x 8
10	Drilling Area Surface Smoothness		OK	Tapping Hole
11	Tapping Operator		MIC Shop	Hex - 19 85 mm ✓
12	Tapping PCD		φ 725 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 32.3 mm Tapping Depth 29.8 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

J. J. 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 - 60

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	φ 4.3	outside	4 mm dia		
3	External Relief Depth	18 mm	(3-3)	11 mm		
4	Inspection Done Before Hardening By (Name)		Sanjay			
5	Material Sent For Hardening By (Name)		W. K. Kumar			
6	Material Sent For Hardening On Date		20	11	24	

### Inspected By (Sign) & Date

J. J. 20/11/24

Reviewed by (Engineer-CNC)

Manager-QA