



# 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.		13349	
2	Machined By		UTK - MIC Shop	30/50
3	Pallet Die No.		13394 (3-0) mm	Drng H- 578 Rev 01
4	Die Category	Drg. No.	SSGW	
5	Out Side Diameter	Drg. No.	620 mm	OD Step - 615.5 mm
6	Inside Diameter	Drg. No.	520 mm	Step length - 20 mm
7	Width of Pellet Die	Drg. No.	222 mm	Tapper 4°
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping Hole
10	Drilling Area Surface Smoothness		OK	Holes - 12
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 - 20.3 mm	Tapping Depth - 18 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Jan 21/11/24	
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	
<b>Note : Mark the defective holes/missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	OK		
2	External Relief Dia	φ 3.3	outside	INNER
3	External Relief Depth		23 mm (3-3)	20 mm
4	Inspection Done Before Hardening By (Name)		Sanjay	
5	Material Sent For Hardening By (Name)		Hark	Feb 2013
6	Material Sent For Hardening On Date		21	24
Inspected By (Sign) & Date			Jan 21/11/24	

Sanjay 21/11/24

Reviewed by (Engineer-CNC)

Manager-QA