



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.		13355 ✓	
2	Machined By		U7L-MIC Shop	
3	Pallet Die No.		11874 (5-0) mm	Step No 633
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	620 mm, OD Step - 623.5 mm	step height 2mm
6	Inside Diameter	Drg. No.	520 mm	Under - 1.5mm
7	Width of Pellet Die	Drg. No.	186 mm	Tapping 12'
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Tapping Ho of
11	Tapping Operator		MIC Shop	fields - 12
12	Tapping PCD		565 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 - 20.4 mm Tapping Depth 18.8 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Jan 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

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	φ 5.5	outside	21 H2R		
3	External Relief Depth		25 mm (3-3)	20 mm		
4	Inspection Done Before Hardening By (Name)		Jan Jan			
5	Material Sent For Hardening By (Name)		Kark Purnu			
6	Material Sent For Hardening On Date		21	11	24	

Inspected By (Sign) & Date

Jan Jan 21/11/24

Reviewed by (Engineer-CNC)

Manager-QA