



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)

858/

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13410	
2	Machined By		UTL - MIC Shop	36/40
3	Pallet Die No.		11825 (30) mm	Drjt-15012 Rev 0
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm	Step length 18
6	Inside Diameter	Drg. No.	420 mm	Tapper 12
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Tapping Head
11	Tapping Operator		MIC Shop	Head - 8
12	Tapping PCD		454 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 - 18.3 mm	Tapping Depth - 16.5 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sanjay 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

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	φ 3.3	out side	4mm			
3	External Relief Depth		10mm (R)	4mm			
4	Inspection Done Before Hardening By (Name)		Sanjay				
5	Material Sent For Hardening By (Name)		Wats Perma				
6	Material Sent For Hardening On Date		21	11	24		

Inspected By (Sign) & Date

Sanjay 21/11/24

Sanjay 21/11/24

Reviewed by (Engineer-CNC)

Manager-QA