



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)

8591

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13373 ✓	
2	Machined By		UTL - MIC Shap	40/50
3	Pallet Die No.		12975 (30)	Drum - 70 Pwco
4	Die Category	Drg. No.	M. Jumbo ✓	
5	Out Side Diameter	Drg. No.	700 mm, Ø Step-703 mm	Step height - 23.5
6	Inside Diameter	Drg. No.	600, 601 mm	Under - 1.5
7	Width of Pellet Die	Drg. No.	250 mm	Tapper 4°
8	Grooves as per Drawing	Drg. No.	24x5x9 mm, 24x5x8.5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	(Tapping Head)
11	Tapping Operator		MIC Shap	Hole - 12)
12	Tapping PCD		655 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 - 24.2 mm	Tapping Depth - 22.5 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Jan Jan 22/11/24

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	Ø 3.5	outside	1MMER		
3	External Relief Depth		16mm (3-3)	10mm ✓		
4	Inspection Done Before Hardening By (Name)		Jan Jan			
5	Material Sent For Hardening By (Name)		work firm			
6	Material Sent For Hardening On Date		22	11	24	

Inspected By (Sign) & Date

Jan Jan 22/11/24

Jan Jan 22/11/24

Reviewed by (Engineer-CNC)

Manager-QA