



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.		13330	
2	Machined By		V7L - MIC Shop	36/10/10
3	Pallet Die No.		13027 (4.0) mm	Drain III
4	Die Category	Dr. No.	Jumbo	
5	Out Side Diameter	Dr. No.	780 mm	Step Length = 26.5 mm
6	Inside Diameter	Dr. No.	660 mm	
7	Width of Pellet Die	Dr. No.	324 mm	(286 + Bon 3rd)
8	Grooves as per Drawing	Dr. No.	21.5 x 8 x 8 mm	32.18
9	Fitting Sizes on CNC Plate	Dr. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping Area of
11	Tapping Operator		MIC Shop	Holes - 12 Both Sides
12	Tapping PCD		425 mm	
13	Tapping Hole Diameter		M20 Check M20 Bolt	(Undercut = 6 mm)
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth 31.5 mm	Tapping Dep 29.5
16	Perpendicularity of Tapped Hole		OK	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Jagan 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	4.5, 5.0	4.5	5.0		
3	External Relief Depth		24 mm	10 mm		
4	Inspection Done Before Hardening By (Name)		Sanjay			
5	Material Sent For Hardening By (Name)		Heer Kumar			
6	Material Sent For Hardening On Date		20	11	24	

Inspected By (Sign) & Date

Jagan 20/11/24

Satish 20/11/24

Reviewed by (Engineer-CNC)

Manager-QA