



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9741	30/40/70
2	Machined By		Mic Shap	Drg No. 397 R
3	Pallet Die No.		10479 (G.O)	(Rev 02)
4	Die Category	Drg. No.	Midrambo	
5	Out Side Diameter	Drg. No.	688 mm	Step Length: 38.5
6	Inside Diameter	Drg. No.	548.1	
7	Width of Pellet Die	Drg. No.	215 mm	→ taper 5°
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	→ Tapping Holes
11	Tapping Operator		Mic Shap	Holes Both Side
12	Tapping PCD		618 mm	(Face Green Both Side)
13	Tapping Hole Diameter		M16 (check M16 Bolt)	1 mm
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 32.5	Tapping Depth - 30.5 mm
16	Perpendicularity of Tapped Hole		OK	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			J. J. 22/6/23	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		N/A	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK (30°)		
2	External Relief Dia	Ø6.5 Ø7.3	Ø6.5 All 4 mm	7.3 All 4 mm
3	External Relief Depth		40 mm	30 mm
4	Inspection Done Before Hardening By (Name)		Sanjay	
5	Material Sent For Hardening By (Name)		H.T. Manager	
6	Material Sent For Hardening On Date		22	6 23
Inspected By (Sign) & Date			J. J. 22/6/23	

Reviewed by (Engineer-CNC)

Manager-QA