



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.		9777	
2	Machined By		U7h - MIC Shop	27/40
3	Pallet Die No.		9784 (3.0 m)	Drg No - hark Ste
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm OD Step - 491 mm	Step height - 12.5
6	Inside Diameter	Drg. No.	420 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm	(Flapping No of
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Holes - R Both
10	Drilling Area Surface Smoothness		OK	Side)
11	Tapping Operator		MIC Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20 (check M20 Belt)	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Dep M - 18.5 mm	Tapping Depth - 16.8 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

J anju 27/6/23

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		No

Note : Mark the defective holes/missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5	outside	13 mm			
3	External Relief Depth		16 mm (2-2)	13 mm			
4	Inspection Done Before Hardening By (Name)		Sanjeev				
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		27	6	13		

Inspected By (Sign) & Date

J anju 27/6/23

Reviewed by (Engineer-CNC)

Manager-QA