



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)

10068

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		In to 15224	
2	Machined By		U7h - MIC Shop	39150
3	Pallet Die No.		14655 (4.0) mm	Dry H- back 970
4	Die Category	Drg. No.	SSC W	
5	Out Side Diameter	Drg. No.	620 mm, OD Step - 612 mm	Step height - 135
6	Inside Diameter	Drg. No.	520 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping Hole
11	Tapping Operator		MIC Shop	Holes - 12
12	Tapping PCD		565 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 - 20.2 mm	Tapping Depth - 18.0
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Jan 12/6/25

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 4.5	outside	inside			
3	External Relief Depth		15 mm (3-3)	11 mm	all		
4	Inspection Done Before Hardening By (Name)		Sanju				
5	Material Sent For Hardening By (Name)		Lark Pinner				
6	Material Sent For Hardening On Date		12	6	25		

Inspected By (Sign) & Date

Jan 12/6/25

Reviewed by (Engineer-CNC)

Manager-QA