



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.		9576	
2	Machined By		U 7L - MIC Shop	50/60
3	Pallet Die No.		9957 (5-0 mm)	Drg No 815AHB ✓
4	Die Category	Drg. No.	M-84umbo	(Rev 00)
5	Out Side Diameter	Drg. No.	750 mm OD Step - 754 mm	Step Height - 29 mm
6	Inside Diameter	Drg. No.	630 mm	
7	Width of Pellet Die	Drg. No.	256 mm	- taper 10°
8	Grooves as per Drawing	Drg. No.	19.5 x 10 x 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Undercut = 2 mm
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MIC Shop	(Tapping No at
12	Tapping PCD		690 mm	Holes - 12 Both
13	Tapping Hole Diameter		M24 (check M24 Belt)	Side) ✓
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 28.5 mm	Tapping Depth - 26.5 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sanjeev 24/6/23	
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	φ 5.5	outside	INNER
3	External Relief Depth		15 mm (B-S)	10 mm
4	Inspection Done Before Hardening By (Name)		Sanjeev	
5	Material Sent For Hardening By (Name)			
6	Material Sent For Hardening On Date		24	6
Inspected By (Sign) & Date			Sanjeev 24/6/23	

Reviewed by (Engineer-CNC)

Manager-QA