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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.		15902	
2	Machined By		UHL MIC 8th	30/66
3	Pallet Die No.		15G28 C6.0	Drum 320 Rnd
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 mm OD Step - 693 mm	Step height - 31 mm
6	Inside Diameter	Drg. No.	546.1 mm	Tap 8°
7	Width of Pellet Die	Drg. No.	195 mm	Welded 2-8
8	Grooves as per Drawing	Drg. No.	32 X 7 X 9.1 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MIC 8th	Flapping No. of
12	Tapping PCD		619 mm	Both - 2 Both side
13	Tapping Hole Diameter		M 16 check by MIC 8th	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 33.3 mm	Tapping Depth - 31.4 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Jag - 1/9/25	
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	27.0	36 small	
3	External Relief Depth			
4	Inspection Done Before Hardening By (Name)			
5	Material Sent For Hardening By (Name)		Lark Pinal	
6	Material Sent For Hardening On Date		19/25	
Inspected By (Sign) & Date			Jag - 1/9/25	

Reviewed by (Engineer-CNC)

Manager-QA