



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

6314

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.			
2	Machined By		10475	
3	Pallet Die No.		072-MK Shop	40/40
4	Die Category	Drg. No.	10682 (5.0) mm	Drg No-15062 Approved
5	Out Side Diameter	Drg. No.	Sciner	
6	Inside Diameter	Drg. No.	500 mm OD Step-499 mm	Tapper 12°
7	Width of Pellet Die	Drg. No.	420 mm	Step height-18 mm
8	Grooves as per Drawing	Drg. No.	158 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 mm 11.8x8x3 mm	
10	Drilling Area Surface Smoothness		ok	Tapping No of
11	Tapping Operator		ok	Holes-8
12	Tapping PCD		MIC Shop	Both side
13	Tapping Hole Diameter		454 mm	
14	Tapping On Second Side	Half pitch of 1st side	M20 (check M20 Bolt)	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Total Depth-20mm Tapping Depth-18mm	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Jan 25/10/23

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		110

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

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	15.3	outside		2 HMMK		
3	External Relief Depth		4 mm (2-2)		TKL		
4	Inspection Done Before Hardening By (Name)		Sciner				
5	Material Sent For Hardening By (Name)		Kok Farmer				
6	Material Sent For Hardening On Date		25	10	23		

Inspected By (Sign) & Date

Jan 25/10/23

Reviewed by (Engineer-CNC)

Manager-QA