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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.		10417	
2	Machined By		U7h- MIC Shop	33/66
3	Pallet Die No.		1191 (6.0) mm	Drg No 6.9
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 mm Step OD-693 mm	Tapper 8°
6	Inside Diameter	Drg. No.	548.1	Step height = 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under-Cal = 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 9 x 8 mm	(4x8)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Race Step = 2 mm
10	Drilling Area Surface Smoothness		OK	Both Sides
11	Tapping Operator		MIC Shop	
12	Tapping PCD		619 mm	Tapping No. of
13	Tapping Hole Diameter		M16 Check M16 Ball	Hole - 4 Both Sides
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 33.4 mm	Tapping Depth - 31.8 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

*[Signature]* 20/11/23

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 (30°)				
2	External Relief Dia	Ø 7.5	outside		4MMH	
3	External Relief Depth		33	All	33 mm	all
4	Inspection Done Before Hardening By (Name)					
5	Material Sent For Hardening By (Name)					
6	Material Sent For Hardening On Date		20	11	23	

### Inspected By (Sign) & Date

*[Signature]* 20/11/23

*[Signature]* 20/11/23  
Reviewed by (Engineer-CNC)

Manager-QA