



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.		13257 ✓	
2	Machined By		VTL - MIC Shop	38645
3	Pallet Die No.		13383 (3.2) mm	Drg. It 527 Rnd
4	Die Category	Drg. No.	SSCW	
5	Out Side Diameter	Drg. No.	610 mm OD Step - 623 mm	Step Length - 18 mm
6	Inside Diameter	Drg. No.	520 mm	
7	Width of Pellet Die	Drg. No.	222 mm	Cracks cut - 6.5 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	Flapping Ho of
11	Tapping Operator		MIC Shop	Holes - 12 Body (✓)
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 mm Tapping Depth - 18.3 mm	
16	Perpendicularity of Tapped Hole		✓	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

J. Anand 13/11/24

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

Counter Sinking Depth & Finish	OK				
External Relief Dia	Ø 3.5	outside	INNER		
External Relief Depth		13 mm (3-3)	7 mm		
Inspection Done Before Hardening By (Name)		Sanju			
Material Sent For Hardening By (Name)		hate firm			
Material Sent For Hardening On Date		13/11	24		

Inspected By (Sign) & Date

S. Anand 13/11/24

J. Anand 13/11/24

Inspected by (Engineer-CNC)

Manager-QA