



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.		13267	
2	Machined By		V71-MK Shap	25/00
3	Pallet Die No.		13144 (3-0) mm	Depth 9980 μ
4	Die Category	Drg. No.	SSC 10	
5	Out Side Diameter	Drg. No.	620 mm, OD Shp. 620 mm	Step height: 18 mm
6	Inside Diameter	Drg. No.	520 mm	
7	Width of Pellet Die	Drg. No.	222 mm	Tapper 12°
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping Me of
10	Drilling Area Surface Smoothness		OK	Holes - 12 holes
11	Tapping Operator		MK Shap	
12	Tapping PCD		585 mm	
13	Tapping Hole Diameter		M20 checks M20 Belt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 20.2 mm Tapping Depth 18.5 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Janj 20/11/24

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

Comments - 60

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	φ 3.3	outside	MM&P		
3	External Relief Depth		28 mm (3-5)	22		
4	Inspection Done Before Hardening By (Name)		Sanjiv			
5	Material Sent For Hardening By (Name)		hank	Pranav		
6	Material Sent For Hardening On Date		20	11	24	

Inspected By (Sign) & Date

Janj

Sanjiv 20/11/24

Reviewed by (Engineer-CNC)

Manager-QA