



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.		9772	36146/55
2	Machined By		M/C Shop	46/55
3	Pallet Die No.		9405 (6.0mm)	Drg No 14924
4	Die Category	Drg. No.	85ew	(Rev 00)
5	Out Side Diameter	Drg. No.	629.2 mm OD Step - 612 mm	Step height = 19.5 mm
6	Inside Diameter	Drg. No.	520 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	Tapping No of
9	Fitting Sizes on CNC Plate	Drg. No.	ok	only - 12
10	Drilling Area Surface Smoothness		ok	Both Side
11	Tapping Operator		M/C Shop	
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		Tapping Drilling Depth - 20.4 mm	Tapping Depth - 18.8
16	Perpendicularity of Tapped Hole		xy	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Janju 22/6/23

1	As per programme no.		ok	
2	Gun Drilling Work Completed On		NO	
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	ø4.5/ø5.0	M5 All Lin	ø5.0 All Lin		
3	External Relief Depth	1.9 mm	1.9 mm	9 mm		
4	Inspection Done Before Hardening By (Name)		Sanju			
5	Material Sent For Hardening By (Name)		LUT - Manab			
6	Material Sent For Hardening On Date		22	6	23	

Inspected By (Sign) & Date

Janju 22/6/23

Reviewed by (Engineer-CNC)

Manager-QA