



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.		9754	
2	Machined By			28/38/60
3	Pallet Die No.		MIC Shop 076	
4	Die Category	Drg. No.	10448 (Mumbo 6.0)	Drg No - 654 (Pewee)
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	720 mm	OD Step - 692 mm
7	Width of Pellet Die	Drg. No.	600 mm	Step height - 19 mm
8	Grooves as per Drawing	Drg. No.	222 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	36 X 10 X 7 mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		MIC Shop	
13	Tapping Hole Diameter		645 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		Drilling Depth - 20.4 mm	Tapping Depth 18.8
17	Visual Inspection Before Gun Drilling		OK YES NO OK	

Inspected By (Sign) & Date

1	As per programme no.		Janjan 22/6/23
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				
2	External Relief Dia	96.5 / 97.0	All Aw 6.5	All Lim 7.0		
3	External Relief Depth		32	22		
4	Inspection Done Before Hardening By (Name)		Sanjeev			
5	Material Sent For Hardening By (Name)		LUT Manager			
6	Material Sent For Hardening On Date		22	6	23	

Inspected By (Sign) & Date

Janjan 22/6/23

Reviewed by (Engineer-CNC)

Manager-QA