



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9771	40/50/60 ✓ Rev. no
2	Machined By		VTL	Dr. H. 727 ✓
3	Pallet Die No.		10568 (4.0) - 1st run	
4	Die Category	Drg. No.	24umbo	
5	Out Side Diameter	Drg. No.	780 mm OD Step 792 mm	Step height = 26.5 mm
6	Inside Diameter	Drg. No.	660 mm	
7	Width of Pellet Die	Drg. No.	324 mm	face broaw = 1 mm
8	Grooves as per Drawing	Drg. No.	21.5 X 8 X 8 mm	Both side ✓
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	(Tapping Hole)
11	Tapping Operator		MIC Shap	Holen - 12 Both
12	Tapping PCD		725 mm	Side) ✓
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 - 31.5 mm Tapping Depth - 29.8 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	Undercut = 6 mm

Inspected By (Sign) & Date

Janjan 22/6/23

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				
2	External Relief Dia	4.3 & 4.8	4.3 All Line	4.8 All Line		
3	External Relief Depth		2mm	10mm		
4	Inspection Done Before Hardening By (Name)		Sanjay			
5	Material Sent For Hardening By (Name)		L.V. Mamejer			
6	Material Sent For Hardening On Date		22	6	23	

Inspected By (Sign) & Date

Janjan 22/6/23

Reviewed by (Engineer-CNC)

Manager-QA