



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.		9275	24/30/50.
2	Machined By		MIC Shop	30/50
3	Pallet Die No.		10321 (40)	Dring Hu karksta
4	Die Category	Drg. No.	SS2W	
5	Out Side Diameter	Drg. No.	620 mm OD Step - 612 mm	Step height - 19.5
6	Inside Diameter	Drg. No.	520 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13 X 8 X 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping Ho cy
10	Drilling Area Surface Smoothness		ok	Ho cy Both side
11	Tapping Operator		MIC Shop	12
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 (check MIC Ball)	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drilling Depth - 20.5 mm Tapping Depth - 18.8 mm	
16	Perpendicularity of Tapped Hole		ok	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

J. Anjan 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, 4.5	4.3 All in	4.5 All in		
3	External Relief Depth		26 mm	20 mm		
4	Inspection Done Before Hardening By (Name)		Sanjiv			
5	Material Sent For Hardening By (Name)		LUT - Manager			
6	Material Sent For Hardening On Date		22	06	23	

Inspected By (Sign) & Date

J. Anjan 22/6/23

Reviewed by (Engineer-CNC)

Manager-QA