



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.		9947	
2	Machined By		UPL	45/50
3	Pallet Die No.		10305 (4.0m)	Dry H=13760 (Pewo)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 mm OD Step - 49/mm	Step Stephyt 17.5m
6	Inside Diameter	Drg. No.	420 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	(Tapping Method)
10	Drilling Area Surface Smoothness		ok	Hole - 8 Both Side) ✓
11	Tapping Operator		MIC Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20 (Check M20 Belt)	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drilling Depth - 18.6 mm Tapping Depth - 16.8 mm	
16	Perpendicularity of Tapped Hole		yy	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Janju 23/6/23	
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	φ4.3	outside 3-3	4mmes
3	External Relief Depth		7mm	5mm
4	Inspection Done Before Hardening By (Name)		Sanju	
5	Material Sent For Hardening By (Name)			
6	Material Sent For Hardening On Date		23 6 23	
Inspected By (Sign) & Date			Janju 23/6/23	

Reviewed by (Engineer-CNC)

Manager-QA