



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.		9770	
2	Machined By		9770	38/50
3	Pallet Die No.		10304 (40)mm	Dry fit - 522 R 00
4	Die Category	Drg. No.	Service	
5	Out Side Diameter	Drg. No.	520 mm OD Step - 500 mm	Step height - 18 mm
6	Inside Diameter	Drg. No.	420 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 3 mm	Grapping No of
9	Fitting Sizes on CNC Plate	Drg. No.	OK	1045 - 8 Boh side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MIC shop	Tapper 10°
12	Tapping PCD		455 mm	
13	Tapping Hole Diameter		M20 (check M20 Ball)	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 18.3 mm Tapping Depth - 16.8 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

J. Anjan 23/6/13

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	Ø4.5	outside	4MM 3/4		
3	External Relief Depth		16mm (2-2)	12 mm		
4	Inspection Done Before Hardening By (Name)		Sanjay			
5	Material Sent For Hardening By (Name)					
6	Material Sent For Hardening On Date		23	6	23	

Inspected By (Sign) & Date

J. Anjan 23/6/13

Reviewed by (Engineer-CNC)

Manager-QA