



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.		9450 to 9827	
2	Machined By			36/40
3	Pallet Die No.		9762 (3.0)	36/40 Aero Drg No - 1506
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm OD Step - 599 mm	Step height 18 mm
6	Inside Diameter	Drg. No.	420 mm	
7	Width of Pellet Die	Drg. No.	158 158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	(Tapping Holes)
10	Drilling Area Surface Smoothness		OK	Holes - 8 Both Side)
11	Tapping Operator		MIC Shop	
12	Tapping PCD		474 mm	
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 - 18.3 mm Tapping Depth - 16.7 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Janjan 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	φ 3.3	outside	1MM2R			
3	External Relief Depth		10mm (2-2)	4mm			
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

Janjan 23/6/23

Reviewed by (Engineer-CNC)

Manager-QA