



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.		9761	
2	Machined By		VTL - MC Shop	39/50
3	Pallet Die No.		10323 (3.5mm)	Dry hole hole (st)
4	Die Category	Drg. No.	55EW	
5	Out Side Diameter	Drg. No.	620 mm	
6	Inside Diameter	Drg. No.	520 mm	OD Step - 612 mm Step height - 19.5 mm
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	(Tapping No of
11	Tapping Operator		MC Shop	holes - 12 Both
12	Tapping PCD		565 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 - 20.5 mm Tapping Depth - 18.7 mm	
16	Perpendicularity of Tapped Hole		yes	
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	Ø 40 mm	outside	1 MMER			
3	External Relief Depth		18 mm (3-3)	11			
4	Inspection Done Before Hardening By (Name)		Sanyan				
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