



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9805	
2	Machined By		VTL-142	39/50
3	Pallet Die No.		10017 (8.0 mm)	Drng. No. 9980 Rev
4	Die Category	Drg. No.	SSW	
5	Out Side Diameter	Drg. No.	620 mm - Lapper 12°	Step Length - 21 mm
6	Inside Diameter	Drg. No.	520 mm	Ⓟ
7	Width of Pellet Die	Drg. No.	228 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	(Lapping Head)
11	Tapping Operator		Mish MIC Shop	Hole - 12 Both Side
12	Tapping PCD		565 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 - 20.5 mm Tapping Depth - 18.5 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

J anju 24/8/23

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	Ⓟ 3.3	outside	1mm		
3	External Relief Depth	✓	17 mm (3-37)	11 mm		
4	Inspection Done Before Hardening By (Name)		Sanjay			
5	Material Sent For Hardening By (Name)					
6	Material Sent For Hardening On Date		24	6	25	

Inspected By (Sign) & Date

Sanjay 24/8/23

Reviewed by (Engineer-CNC)

Manager-QA