



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.		9781	
2	Machined By			28/50 ✓
3	Pallet Die No.		9821 (4.0 m)	Dmg. Hr. 419 AM ✓
4	Die Category	Drg. No.	M. dumbo	
5	Out Side Diameter	Drg. No.	700 mm OD Step-692 mm	Step height 19.5 mm ✓
6	Inside Diameter	Drg. No.	600 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	12-5 X 1/2 X 7 mm	Tapping Hole ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Hole - 12 BOM ✓
10	Drilling Area Surface Smoothness		ok	Ed 4 ✓
11	Tapping Operator		MIC Sheld	
12	Tapping PCD		645 mm	
13	Tapping Hole Diameter		100 M20 (check M20 Bell)	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drilling Depth-22.5 mm Tapping Depth-20.7 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Janjan 27/6/23

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	Ø4.5	outside	1 HMM			
3	External Relief Depth	✓	26 y (3-3)	22 mm			
4	Inspection Done Before Hardening By (Name)		Sanjay				
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		27	6	23		

Inspected By (Sign) & Date

Janjan 27/8/23

Reviewed by (Engineer-CNC)

Manager-QA