



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.		9764	
2	Machined By		VTL - MIC Shop	38140
3	Pallet Die No.		9800 (40m)	Drg No - 400 Rev
4	Die Category	Drg. No.	Service	
5	Out Side Diameter	Drg. No.	500 mm OD Step - 492 mm	Step height - 13.5 mm
6	Inside Diameter	Drg. No.	420 mm	
7	Width of Pellet Die	Drg. No.	157 mm 159 mm	
8	Grooves as per Drawing	Drg. No.	7 x 7 x 5 mm	Tapping Ho of Holes & Body etc
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MIC Shop	(280 + Both side)
12	Tapping PCD		455 mm	20-2 x 7 mm
13	Tapping Hole Diameter		φ 3/4" check Belt)	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 22.5 mm Tapping Depth - 20.5 mm	
16	Perpendicularity of Tapped Hole		Yul	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date				
Janju 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		φ 4.5 mm	outer
3	External Relief Depth		6 mm (2-2)	INNER 2 mm
4	Inspection Done Before Hardening By (Name)		Sanjeev	
5	Material Sent For Hardening By (Name)			
6	Material Sent For Hardening On Date		27 6 23	
Inspected By (Sign) & Date				
Janju 27/6/23				

Reviewed by (Engineer-CNC)

Manager-QA