



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.		9795	
2	Machined By		U7h MIC Shop	34/80
3	Pallet Die No.		10020 (2.8 m)	Drng No 9980 Rev
4	Die Category	Drg. No.	SS&W	
5	Out Side Diameter	Drg. No.	620 mm Tapper 12°	Step height - 20.5 m
6	Inside Diameter	Drg. No.	520 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	Tapping Hole
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Hole - 12 Both side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		MIC Shop	
12	Tapping PCD		565 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 20.6 mm Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

[Signature] 26/6/23

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	∅ 3.1	outside	4H max		
3	External Relief Depth	22 mm	3-3	18 mm		
4	Inspection Done Before Hardening By (Name)		Sanjeev			
5	Material Sent For Hardening By (Name)					
6	Material Sent For Hardening On Date		26	6	23	

Inspected By (Sign) & Date

[Signature] 26/6/23

Reviewed by (Engineer-CNC)

Manager-QA