



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.		9684	
2	Machined By		V7L MIC Shop	44/50
3	Pallet Die No.		10037 (3.5) mm	Flange to back side
4	Die Category	Drg. No.	SSCW	
5	Out Side Diameter	Drg. No.	620 mm OD STEP - 612 mm	Step height - 19.5
6	Inside Diameter	Drg. No.	520 mm	
7	Width of Pellet Die	Drg. No.	292 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping Ho up
10	Drilling Area Surface Smoothness		ok	Holes - 12 Both
11	Tapping Operator		MIC Shop	Side)
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		MIC Shop Drilling Depth - 20.6 mm	Tapping Depth
16	Perpendicularity of Tapped Hole		xy	18.6
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Janju 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)		40	

Note : Mark the defective holes/missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.0	outside	1MM			
3	External Relief Depth		13mm (B-3)	6mm			
4	Inspection Done Before Hardening By (Name)		Janju				
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		26	6	23		

Inspected By (Sign) & Date

Janju 26/6/23

Reviewed by (Engineer-CNC)

Manager-QA