



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.		9814	
2	Machined By		VTL M/C SHOP	39/50
3	Pallet Die No.		9989 (3.5)	Drg No - hunkstol
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.	222.2 mm (A)	
8	Grooves as per Drawing	Drg. No.	13A875	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping Mandrel holes - 12 Both sides
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 - 20.5 mm Tapping Depth - 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sanjiv 28/6/23

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	040 040	outside	inner		
3	External Relief Depth		18 mm (3-3)	11 mm		
4	Inspection Done Before Hardening By (Name)		Sanjiv			
5	Material Sent For Hardening By (Name)					
6	Material Sent For Hardening On Date		26	6	23	

Inspected By (Sign) & Date

Sanjiv 28/6/23

Reviewed by (Engineer-CNC)

Manager-QA