



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.		9295	
2	Machined By		VTL MIC Shop	120/120
3	Pallet Die No.		10460 (3.0m)	Drg No - 559 Rev 0
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	870 mm OD Step - 743.5 mm	Step length - 23
6	Inside Diameter	Drg. No.	630 mm	
7	Width of Pellet Die	Drg. No.	265 mm	
8	Grooves as per Drawing	Drg. No.	15 x 8 x 5 mm	Tapper 10°
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	(Tapping Head Holes - 16 Both side)
11	Tapping Operator		MIC Shop	
12	Tapping PCD		685 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 - 18.9 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Janji 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	—	MILL		MILL		
3	External Relief Depth		—		—		
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

Janji 26/6/23

Reviewed by (Engineer-CNC)

Manager-QA