



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

8395

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12692	66/66
2	Machined By		V. T. L. N/C Shop	57/66
3	Pallet Die No.		12970 (10.0) H/H	Pyro 18.02.30
4	Die Category	Drg. No.	N. Tomba	Rev. 06
5	Out Side Diameter	Drg. No.	680.1 H/H	Step OD = 693 H/H
6	Inside Diameter	Drg. No.	548. H/H	Tapper = 3°
7	Width of Pellet Die	Drg. No.	195 H/H	Step length = 31 H/H
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/H	Under cut = 2.8 H/H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	(4 x 8)
10	Drilling Area Surface Smoothness		OK	Face side step
11	Tapping Operator		N/C Shop	2 H/H Deep Bottom side
12	Tapping PCD		619 H/H	Tapping Hole of Hole = 8
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Bottom side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 34.5 H/H	Tapping Depth = 31.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 17/10/24

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

Counter = 60°

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	11.0 H/H	[1st Pad]	[2nd]					
3	External Relief Depth		[9 H/H]	[Not Relief]					
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		17	10	24				

Inspected By (Sign) & Date

Ravi 17/10/24

Reviewed by (Engineer-CNC)

Manager-QA