



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.		10943	43/55
2	Machined By		V.T. L.H.C Shop	Drg No. (S.O.) 412
3	Pallet Die No.		11576 (6.0) H.H.	Rev 2.00
4	Die Category	Drg. No.	H. Jamba	
5	Out Side Diameter	Drg. No.	710 H.H. Step 00: 892.8 H.H.	Tapper = 12°
6	Inside Diameter	Drg. No.	600.12 H.H.	Step length = 19.8
7	Width of Pellet Die	Drg. No.	222 H.H.	
8	Grooves as per Drawing	Drg. No.	14x8x7 H.H. / 14x8x7 H.H.	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No of Holes = 12 Both Side
12	Tapping PCD		640 H.H.	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 22.8 H.H. Tapping Depth = 20.8 H.H.	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 12/1/24

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	6.5 H.H.	Outside (3-3)		Inner					
3	External Relief Depth		19 H.H.		13 H.H.					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date			12	1	24				

Inspected By (Sign) & Date

Ravi 12/1/24

Saty 12/1/24

Reviewed by (Engineer-CNC)

Manager-QA