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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.		10056-R1	
2	Machined By		U7L MIC Shop	36/40
3	Pallet Die No.		10066 (4.0 mm)	Dray... hark...
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm OD Step - 491 mm	Step height - 17.5 mm
6	Inside Diameter	Drg. No.	420 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 3 mm	capping & No. of holes - Both side
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MIC Shop	
12	Tapping PCD		454 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 - 18.3 mm Tapping Depth - 16.5 mm	
16	Perpendicularity of Tapped Hole		OK	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

J. Anjan 14/8/23

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	φ 4.3	outside	INNER		
3	External Relief Depth	8 mm	(2x)	4mm		
4	Inspection Done Before Hardening By (Name)	Sanjan				
5	Material Sent For Hardening By (Name)	hark ferrous				
6	Material Sent For Hardening On Date	14	8	23		

Inspected By (Sign) & Date

J. Anjan 14/8/23

Reviewed by (Engineer-CNC)

Manager-QA

T. Anjan 14/8/23