

5945



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.		9965	
2	Machined By		U7K MIC Shop	55/60
3	Pallet Die No.		10449 (10.0mm)	Drg No-408 R-00
4	Die Category	Drg. No.	M- Jumbo	
5	Out Side Diameter	Drg. No.	720mm OD Step	693mm Step height 20mm
6	Inside Diameter	Drg. No.	600 mm	
7	Width of Pellet Die	Drg. No.	222 mm	Tapper 12'
8	Grooves as per Drawing	Drg. No.	12 X 8 X 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	(Capping Hole)
11	Tapping Operator		MIC Shop	Holes Both side
12	Tapping PCD		640 mm	12)
13	Tapping Hole Diameter		M20 check M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth-20.5mm Tapping Depth-18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Janjan 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	Ø 10.5	outside	1mm		
3	External Relief Depth		15mm (3-3)	5mm	ASP	
4	Inspection Done Before Hardening By (Name)		Sanjan			
5	Material Sent For Hardening By (Name)		work Perma			
6	Material Sent For Hardening On Date		14	8	23	

Inspected By (Sign) & Date

Janjan 14/8/23

Tanujit 14/8/23

Reviewed by (Engineer-CNC)

Manager-QA