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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.		13168	28/66
2	Machined By		VRL MIC Shop	
3	Pallet Die No.		13624 (6.0)mm	Dry run - 320 Revs
4	Die Category	Dr. No.	M. Jumbo	
5	Out Side Diameter	Dr. No.	680.1mm Steped - 693	Tapper 8°
6	Inside Diameter	Dr. No.	548.1mm Bor 548.1, Step height 31mm	
7	Width of Pellet Die	Dr. No.	195mm	
8	Grooves as per Drawing	Dr. No.	32 X 7 X 9mm	(4 X 8) mm Center
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		MIC Shop	face side 2mm Dap both side
12	Tapping PCD		619mm	
13	Tapping Hole Diameter		MIG Check by MIG Babb	Tapping Hole ok
14	Tapping On Second Side	Half pitch of 1st side	ok	Hole - 2
15	Tapping Hole Depth		Drilling Dep - 34mm Tapping Depth - 32mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sanjay 7/11/24

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

1	Counter Sinking Depth & Finish	ok						Counter - 30°
2	External Relief Dia	0.70	outside	ok	inside			
3	External Relief Depth		41mm		41mm			
4	Inspection Done Before Hardening By (Name)		Sanjay					
5	Material Sent For Hardening By (Name)		hark		form			
6	Material Sent For Hardening On Date		7	11	24			

Inspected By (Sign) & Date

Sanjay 7/11/24

Reviewed by (Engineer-CNC)
Sanjay 7/11/24

Manager-QA