

8499



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.		13222 ✓	
2	Machined By		VTL MIC Shop	40/50 ✓
3	Pallet Die No.		13443 (40) mm ✓	Drngt 21 Prop ✓
4	Die Category	Drg. No.	Senior ✓	
5	Out Side Diameter	Drg. No.	520 mm OD Step. 10.499 mm ✓	Step height - 12 ✓
6	Inside Diameter	Drg. No.	420 mm ✓	
7	Width of Pellet Die	Drg. No.	158 mm ✓	(Chaper 12°) ✓
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		MIC Shop	Tapping Ho of Holes - 8 Both ✓
12	Tapping PCD		454 mm ✓	
13	Tapping Hole Diameter		φ 3/4" Check by φ 3/4" Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drilling Depth - 22 mm Tapping Depth - 20 mm ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sanjeev 8/11/24

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				
2	External Relief Dia	φ 4.5	outside	INNER		
3	External Relief Depth		14 mm (R-2)	10 mm		
4	Inspection Done Before Hardening By (Name)		Sanjeev			
5	Material Sent For Hardening By (Name)		Harsh Kumar			
6	Material Sent For Hardening On Date		8	11	24	

Inspected By (Sign) & Date

Sanjeev 8/11/24

Sanjeev 8/11/24

Reviewed by (Engineer-CNC)

Manager-QA