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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.		13135 ✓	
2	Machined By		V76 MICShop	45/60
3	Pallet Die No.		12856 (8.0) mm	Drill 1174 Rev
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	720 mm	Stepod - 693 mm, Step length - 20 mm
6	Inside Diameter	Drg. No.	600 mm	
7	Width of Pellet Die	Drg. No.	222 mm ✓	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping Ho of Holes - 12 both side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		MIC Shop	(Tapper 12°)
12	Tapping PCD		640 mm ✓	
13	Tapping Hole Diameter		M20 Check M20 Belt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drilling Depth - 20.2 mm Tapping Depth - 18.5 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Jan Jan 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 8.5 mm	outside	B-3)	4MMER	pl
3	External Relief Depth		23 mm		15 mm	
4	Inspection Done Before Hardening By (Name)		Sanyal			
5	Material Sent For Hardening By (Name)		herb	prasad		
6	Material Sent For Hardening On Date		8	11	24	

Inspected By (Sign) & Date

Jan Jan 8/11/24

Sanyal 8/11/24

Reviewed by (Engineer-CNC)

Manager-QA