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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13410 13279	
2	Machined By		VTL MIC Shop	40/40
3	Pallet Die No.		12.695 (5-0) mm	
4	Die Category	Drg. No.	Senior	Drg No - 783 P-20
5	Out Side Diameter	Drg. No.	500 mm	
6	Inside Diameter	Drg. No.	OD Gap - 482 mm	Step height - 17.5 mm
7	Width of Pellet Die	Drg. No.	420 mm	
8	Grooves as per Drawing	Drg. No.	158 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 mm	
10	Drilling Area Surface Smoothness		OK	(Tapping Ho of holes - 8)
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		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Sanju 21/11/24

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

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1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	Ø 5.5	outside	INNER		
3	External Relief Depth	5 mm	Q-27	MILK		
4	Inspection Done Before Hardening By (Name)		Sanju			
5	Material Sent For Hardening By (Name)		hark	Furnace		
6	Material Sent For Hardening On Date		21	11	24	

Inspected By (Sign) & Date

Sanju 21/11/24

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Reviewed by (Engineer-CNC)

Manager-QA