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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.		13306	
2	Machined By		UHL-MIC Shop	28145 28145
3	Pallet Die No.		13388 (2.8) mm	Drg No 644 Rev 00
4	Die Category	Drg. No.	SSCW	
5	Out Side Diameter	Drg. No.	670 mm OD Step - 621.5 mm	Step height - 21.5 mm
6	Inside Diameter	Drg. No.	520 mm	cap dia 12
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13 X 8 X 5 mm	Under cut - 5.8 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MIC Shop	Tapping No of
12	Tapping PCD		565 mm	Hole - 12
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 20.3 mm	Tapping Depth 18.5 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date *[Signature]* 22/11/24

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 Count 60

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	Ø 3.3	outside	1MMGL		
3	External Relief Depth		20 mm (3.7)	17 mm		
4	Inspection Done Before Hardening By (Name)		<i>[Signature]</i>			
5	Material Sent For Hardening By (Name)		Wank Perry			
6	Material Sent For Hardening On Date		22	11	24	

Inspected By (Sign) & Date *[Signature]* 22/11/24

Reviewed by (Engineer-CNC) *[Signature]* 22/11/24

Manager-QA