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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.		13287	
2	Machined By		U7h-MICShop	41/50
3	Pallet Die No.		13448 (60)	Drg No 13760
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 mm / OD Step-491 mm	Step height-17.5
6	Inside Diameter	Drg. No.	420 mm	
7	Width of Pellet Die	Drg. No.	178 mm	
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	Tapping Hole hole - 8 holes
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-18.5 mm	Tapping Depth-16.5
16	Perpendicularity of Tapped Hole		xy	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Jain 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 6.5	out side	2M42	
3	External Relief Depth		11 mm (22)	5 mm	
4	Inspection Done Before Hardening By (Name)		Jain		
5	Material Sent For Hardening By (Name)		Waste	ferme	
6	Material Sent For Hardening On Date		22	11	24

Inspected By (Sign) & Date

Jain 22/12/24

Reviewed by (Engineer-CNC)

Manager-QA