

8.5/15



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.		13328 ✓	
2	Machined By		V7K - MIC Shop	40/40 ✓
3	Pallet Die No.		13040(4.5)(4.0)(4.0)	Dry re-hut 9/14
4	Die Category	Drg. No.	SEW ✓	
5	Out Side Diameter	Drg. No.	500 mm OD step - 491 mm	step height 17.5 mm
6	Inside Diameter	Drg. No.	420 mm	
7	Width of Pellet Die	Drg. No.	182 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm	Tapping 40 of hole - 8
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MIC Shop	
12	Tapping PCD		474 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 - 16.6 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Jagan 20/11/24

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

Counter - 60

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	Ø 4.8	outside	at Hole			
3	External Relief Depth		4 mm	Mark			
4	Inspection Done Before Hardening By (Name)		Jagan				
5	Material Sent For Hardening By (Name)		hark permy				
6	Material Sent For Hardening On Date		20	11	2024		

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA