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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.		13349 ✓	
2	Machined By		Ujh - MIC Shop	30150 ✓
3	Pallet Die No.		13393 (3-0) mm	Length 578 (Re) ✓
4	Die Category	Drg. No.	SS410	
5	Out Side Diameter	Drg. No.	620 mm	Step length - 20 ✓
6	Inside Diameter	Drg. No.	520 mm	Tapper 4° ✓
7	Width of Pellet Die	Drg. No.	13393 222 mm	
8	Grooves as per Drawing	Drg. No.	13X8X5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Tapping Ho of ✓
11	Tapping Operator		MIC Shop	holes - 12 Both ✓
12	Tapping PCD		565 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		ok	
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				Counts - 60
1	Counter Sinking Depth & Finish	ok		
2	External Relief Dia	φ 3.3	outside	4MM ✓
3	External Relief Depth		23 mm (3-3)	20 mm Del ✓
4	Inspection Done Before Hardening By (Name)		Sanju	
5	Material Sent For Hardening By (Name)		hous fermy	
6	Material Sent For Hardening On Date		21 11 24	
Inspected By (Sign) & Date			Sanju 21/11/24	

Reviewed by (Engineer-CNC)

Manager-QA