

8008



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.		13272 ✓	
2	Machined By		V72 MIC Shop	93/40
3	Pallet Die No.		12346 (30) mm ✓	Drilling as per 8/4 ✓
4	Die Category	Drg. No.	Juniar	
5	Out Side Diameter	Drg. No.	400 mm, ab step - 395 mm	Step height - 14 mm ✓
6	Inside Diameter	Drg. No.	320 mm ✓	
7	Width of Pellet Die	Drg. No.	142 mm ✓	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping Hole of ✓
10	Drilling Area Surface Smoothness		ok	Hole - 8 ✓
11	Tapping Operator		MIC Shop ✓	
12	Tapping PCD		355 mm ✓	
13	Tapping Hole Diameter		M16 check M16 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		ok ✓	
17	Visual Inspection Before Gun Drilling		ok ✓	

Inspected By (Sign) & Date

Jaijan 23/11/24

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 - 0 ✓

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	Ø 3.5 mm	outside	4MM ✓			
3	External Relief Depth	✓	13 mm (2-2)	7 mm ✓			
4	Inspection Done Before Hardening By (Name)		Jaijan				
5	Material Sent For Hardening By (Name)		Lark Permy				
6	Material Sent For Hardening On Date		23	11	24		

Inspected By (Sign) & Date

Jaijan 28/11/24

Saty 23/11/24

Reviewed by (Engineer-CNC)

Manager-QA