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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.		10434	40/50/66
2	Machined By		U7L - MIC Shop	38148166
3	Pallet Die No.		11177 (6-0) mm	Drigger 693 Prol
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680-69 mm	Step height - 31 mm
6	Inside Diameter	Drg. No.	548.1	Topper 5°
7	Width of Pellet Die	Drg. No.	195 mm	
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 mm	Center groove - 4 x 8 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Under cut = 2.5 mm
10	Drilling Area Surface Smoothness		OK	(face groove depth 2 mm both side)
11	Tapping Operator		MIC Shop	
12	Tapping PCD		619 mm	Tapping No of
13	Tapping Hole Diameter		M16 (check M16 Belt)	Holes - 4 Both
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 33.3 mm	Tapping Depth - 31.7 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

J. Anjan 20/11/23

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

1	Counter Sinking Depth & Finish	OK (30°)	2 step	71 step	
2	External Relief Dia	6.5, 7.5	26 mm	16 mm	28 ~ 18 mm
3	External Relief Depth		all	all	all
4	Inspection Done Before Hardening By (Name)		Sanjiv		
5	Material Sent For Hardening By (Name)		hark	fernu	
6	Material Sent For Hardening On Date		20	11	23

Inspected By (Sign) & Date

J. Anjan 20/11/23

Saty 20/11/23

Reviewed by (Engineer-CNC)

Manager-QA