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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.		10764	
2	Machined By		VTK MIC-Shop	30170
3	Pallet Die No.		10808 (3.0) mm	Dray H-9580
4	Die Category	Drg. No.	SSEW	(A) (A)
5	Out Side Diameter	Drg. No.	620 mm	Step length: 20 mm Tapper 18.5°
6	Inside Diameter	Drg. No.	520 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13 X 8 X 5 mm	(Tapping No. of Holes Both Sides)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	12)
11	Tapping Operator		MIC Shop	
12	Tapping PCD		565 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-20.1mm Tapping Depth-18.5mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *[Signature]* 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						
2	External Relief Dia	Ø 3.5	outside		4MMZP			
3	External Relief Depth		23	(3-3)	20	ALL		
4	Inspection Done Before Hardening By (Name)		Sanjeev					
5	Material Sent For Hardening By (Name)		huck punner					
6	Material Sent For Hardening On Date		20	11	23			

Inspected By (Sign) & Date *[Signature]* 20/11/23

[Signature]
 20/11/23
 Reviewed by (Engineer-CNC)

Manager-QA