



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.		15054	
2	Machined By		UPL MLC Shop	55/55
3	Pallet Die No.		15468 (8.0) mm	Drum 453 Rop
4	Die Category	Drg. No.	J&W	
5	Out Side Diameter	Drg. No.	740.0 mm	Step length - 23.5 mm
6	Inside Diameter	Drg. No.	630 mm	
7	Width of Pellet Die	Drg. No.	290 mm	Topper 12°
8	Grooves as per Drawing	Drg. No.	15 X 8 X 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Under cut - 1.8 mm
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MLC Shop	(Tapping Ho of - 16)
12	Tapping PCD		685 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 - 20.3 mm	Tapping Depth - 18.6 mm
16	Perpendicularity of Tapped Hole		OK	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Sanjay 12/6/15

1	As per programme no.			
2	Gun Drilling Work Completed On			Discussed with
3	Hole Finish In Gun Drilling	Marked	OK	Sochin Sir
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 8.5	outside	Ø 8.5	Ø 8.5		
3	External Relief Depth	Ø 8.5	(3-3)	Ø 8.5	Ø 8.5		
4	Inspection Done Before Hardening By (Name)		Sanjay				
5	Material Sent For Hardening By (Name)		Mark Puro				
6	Material Sent For Hardening On Date		12	6	25		

Inspected By (Sign) & Date

Sanjay 12/6/15

Reviewed by (Engineer-CNC)

Manager-QA