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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 (Pollet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14727	32/40
2	Machined By		V. T. L. H/c Shop	Dy. M. Lark
3	Pallet Die No.		13996 (3.0) H/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.7 H/c Step 00-490.7 H/c Step length	
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c / 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		H202 Check by H2-Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 H/c Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		OK	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 17/4/15	
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		3.5 H/c	
3	External Relief Depth		12 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark For ware	
6	Material Sent For Hardening On Date		17 4 25	
Inspected By (Sign) & Date			Ravi 17/4/15	

Reviewed by (Engineer-CNC)

Manager-QA