

9643

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.			
2	Machined By		14709	34/50
3	Pallet Die No.		V.T.L. n/a Shop	Dyeing 1.2.2-98
4	Die Category	Drg. No.	14620 (4.0) n/a	Ren 200
5	Out Side Diameter	Drg. No.	End side	
6	Inside Diameter	Drg. No.	820 n/a Step 00. Tapper 12°	
7	Width of Pellet Die	Drg. No.	520.12 n/a	Step length 18.5
8	Grooves as per Drawing	Drg. No.	222 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/a 13x8x5 n/a	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/a Shop	[Tapping of Holes 12 Both Side]
13	Tapping Hole Diameter		565 n/a	
14	Tapping On Second Side	Half pitch of 1st side	n/a: Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 n/a Tapping Depth 18.5 n/a	
17	Visual Inspection Before Gun Drilling		yes	
			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)		n/a	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60

1	Counter Sinking Depth & Finish	ok						Row 31
2	External Relief Dia	45 n/a	Outside (3-3)		Inner			
3	External Relief Depth		20 n/a		18 n/a			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Ramesh			
6	Material Sent For Hardening On Date		17	4	25			

Inspected By (Sign) & Date

Ravi 17/4/15

Reviewed by (Engineer-CNC)

Manager-QA