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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 (Pollot Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14849	42/55
2	Machined By		V. T. L. H/c Shop	Drill 1.2.0.355
3	Pallet Die No.		13896(4.0) H/c	Renew
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	329.9 H/c	Step 002 8.2 H/c
6	Inside Diameter	Drg. No.	520.12 H/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	186 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x3 H/c 13x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping of holes 12
12	Tapping PCD		56.5 H/c	Both Side
13	Tapping Hole Diameter		H20. Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	Tapping Dept-18.5
15	Tapping Hole Depth		Drill Depth 20.4 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sasi: 26/4/15	
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		Counter 60
2	External Relief Dia	4.5 H/c	Outside 23.3	Low 25
3	External Relief Depth		17 H/c	13 H/c
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		26	4 25
Inspected By (Sign) & Date			Sasi: 26/4/15	

Reviewed by (Engineer-CNC)

Manager-QA