



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pollot Dia)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14789	33/5
2	Machined By		V. T. L. Nila Shop	Qty. 12.00 931
3	Pallet Die No.		15107 (C 4.0) mm	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5.20 mm, Step 00. 491.7 mm	Step length 13.5
6	Inside Diameter	Drg. No.	4.20. 1.2 mm	
7	Width of Pellet Die	Drg. No.	1.80 mm	
8	Grooves as per Drawing	Drg. No.	10x8x5 mm / 10x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		Nila Shop	[Tapping H. of Holes. B Both Side]
12	Tapping PCD		4.54 mm	
13	Tapping Hole Diameter		03/4" - Check by 03/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 mm	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 2/5/15

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

Counter 60

1	Counter Sinking Depth & Finish	ok						Rev. 21
2	External Relief Dia	4.5 mm	22.25	Inner				
3	External Relief Depth		21 mm	17 mm				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		2	5	25			

Inspected By (Sign) & Date

Ravi 2/5/15

Reviewed by (Engineer-CNC)

Manager-QA