



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 (Pollot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15313	36/55
2	Machined By		V. T. L. H/C Shop	Dr. 21. 12. 45
3	Pallet Die No.		14566(3.5) H/C	Rev. m
4	Die Category	Drg. No.	Jun 60	
5	Out Side Diameter	Drg. No.	770 H/C	Step on. 800 H/C
6	Inside Diameter	Drg. No.	660.14 H/C	Step length 200
7	Width of Pellet Die	Drg. No.	316 H/C	Under cut 15 H/C
8	Grooves as per Drawing	Drg. No.	20x8x7.5 H/C	20x8x7.5 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		725 H/C	
13	Tapping Hole Diameter		H20. Check by H2 Bore	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 25.4 H/C	Tapping Depth. 23
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

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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	4.0 H/C	Outside (3-3)		Inner				
3	External Relief Depth		23 H/C		19 H/C				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		30	6	25				

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA