



Lark Engineering Company (India) Pvt. Ltd.

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

1022-8

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.			
2	Machined By		15364 ✓	40/55 ✓
3	Pallet Die No.		V-7.1. n/c Shop	Dy. 1.12.0.389
4	Die Category	Drg. No.	12398(4.0) n/c	Rev 2.00
5	Out Side Diameter	Drg. No.	2 x 2.5 mm	
6	Inside Diameter	Drg. No.	G30 n/c Shop 0.1 G24 n/c	Tapping 12°
7	Width of Pellet Die	Drg. No.	52.14 n/c	Step length 18 n/c
8	Grooves as per Drawing	Drg. No.	2 x 2.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c	
10	Drilling Area Surface Smoothness	Drg. No.	OK	
11	Tapping Operator		OK	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		58.5 n/c	
14	Tapping On Second Side	Half pitch of 1st side	H2. Check by H2. Ball	Tapping 12° of H. 12° Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 n/c	Tapping Depth 18.0
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

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. 30
2	External Relief Dia	4.5 n/c	20 Side		Inner			31
3	External Relief Depth		19 n/c		15 n/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date							

Inspected By (Sign) & Date

--	--	--	--	--	--	--	--	--

Reviewed by (Engineer-CNC)

Manager-QA