

10215



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 (Pollet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14976	Go/OK
2	Machined By		V. T. L. H/C Shop	Drg. No. 12.0.951
3	Pallet Die No.		15812 (4.5) mm	Revised
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	549.9 mm	Step 00.491 mm
6	Inside Diameter	Drg. No.	420.14 mm	Step length 17.5
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12-8-3 mm	12-8-3 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20. Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.7 mm	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			San: 4/7/15	
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		
2	External Relief Dia	5.0 mm	Outside 22-23	Inner 5 mm
3	External Relief Depth		14 mm	5 mm
4	Inspection Done Before Hardening By (Name)		San	
5	Material Sent For Hardening By (Name)		Lark for hard	
6	Material Sent For Hardening On Date		4	7
Inspected By (Sign) & Date			San: 4/7/15	

Reviewed by (Engineer-CNC)

Manager-QA