



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 Dia)

10322

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		13467 ✓	50/60 ✓
3	Pallet Die No.		V.T.L. H/C Shop	Qty 10, 12, 24, 109
4	Die Category	Drg. No.	102372 (4.0) ✓	Rev. 00
5	Out Side Diameter	Drg. No.	55510	
6	Inside Diameter	Drg. No.	640 H/C Shop 00.812 ✓	Step length 19.5
7	Width of Pellet Die	Drg. No.	520.14 H/C	
8	Grooves as per Drawing	Drg. No.	186 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x3 H/C / 13x8x3 H/C	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping ✓
12	Tapping PCD		565 H/C	of holes 12
13	Tapping Hole Diameter		H20, Check by H20 Bolt	Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 H/C	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Soni 22/7/15	
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		Counter Sink
2	External Relief Dia	4.5 H/C	Outside (3.3)	Inner
3	External Relief Depth		18 H/C	10 H/C
4	Inspection Done Before Hardening By (Name)		Soni	
5	Material Sent For Hardening By (Name)		Lark Surface	
6	Material Sent For Hardening On Date		22 7 25	
Inspected By (Sign) & Date			Soni 22/7/15	

Reviewed by (Engineer-CNC)

Manager-QA