



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 (Polot Dlos)

S.No.	Check Parameter	Specifcation	Observations	Remarks
1	Work Order No.		15516 ✓	32/55 ✓
2	Machined By		V. T. L. H/c Shop	Day Nos 18.0.366
3	Pallet Die No.		14278 (6.0) H/c	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	709.8 H/c	Step 00. 672.8 H/c
6	Inside Diameter	Drg. No.	600.14 H/c	(Bar. 599.2) H/c
7	Width of Pellet Die	Drg. No.	222 H/c	Step length den
8	Grooves as per Drawing	Drg. No.	12x10x7.5 H/c	12x10x7.5 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		640 H/c	
13	Tapping Hole Diameter		H/c	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.4 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	
4	Defective Holes (If Any)		

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 H/c	23-35						
3	External Relief Depth		29 H/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

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Reviewed by (Engineer-CNC)

Manager-QA