



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.		15557	30/49/2179
2	Machined By		V. T. L. H/c Shop	Dy. M. Lark 25/7
3	Pallet Die No.		13749 (4.0) mm	
4	Die Category	Drg. No.	5212	
5	Out Side Diameter	Drg. No.	5 mm	Step on 490.9 mm Step length 1170
6	Inside Diameter	Drg. No.	420.14 mm	
7	Width of Pellet Die	Drg. No.	182 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		M202 Check by H20 Bolt	Tapping H/c of Holes 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 mm	Tapping Depth 18.4
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						Counter B/c Row 2 & 5
2	External Relief Dia	4.5 mm	80 Side	2.2	Inner			
3	External Relief Depth		14 mm		10 mm			
4	Inspection Done Before Hardening By (Name)							Rev:
5	Material Sent For Hardening By (Name)							Lark Parnace
6	Material Sent For Hardening On Date		26	7	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA