



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

Inprocess Inspection (Pollot Dies)

Rev. Date

31-07-2013

10464

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15580	30/45
3	Pallet Die No.		V. T. L. H/c Shop	Drg No. 1.2.0 1385
4	Die Category	Drg. No.	12906 (4.0)	Rev. 00
5	Out Side Diameter	Drg. No.	Extra wide	
6	Inside Diameter	Drg. No.	610mm Step 02, 614mm	
7	Width of Pellet Die	Drg. No.	520.14mm	Step length 19.5
8	Grooves as per Drawing	Drg. No.	222mm	Under cut 2mm
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5mm / 13x8x5mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		565mm	
14	Tapping On Second Side	Half pitch of 1st side	0.314" = Check by 0.314" R. 12	Tapping No. of Holes 12 Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4mm	Tapping Depth 18.4
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		
4	Defective Holes (If Any)		ok	
			No - Hole Closed	

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

1	Counter Sinking Depth & Finish	ok								Counter 60
2	External Relief Dia	4.5mm	Outer (2-3)		Inner					Row 31
3	External Relief Depth		19mm		15mm					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date									
			12	8	25					

Inspected By (Sign) & Date

Reviewed by (Engineer-CNC)

Manager-QA