



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10561

Form No.	CNC/QA/FM/02
Rev. No.	01
Rev. Date	31-07-2013

Inprocess Inspection (Pollock Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15765	45/50
3	Pallet Die No.		V.T.L. H/c Shop	1.8.2013
4	Die Category	Drg. No.	15738(6.0)	Senior
5	Out Side Diameter	Drg. No.	580mm	Step 02. 490.9mm
6	Inside Diameter	Drg. No.	420.14mm	Step length 17.5
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12+8+3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12+8+3mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		454mm	
14	Tapping On Second Side	Half pitch of 1st side	H20 Check by H20 Ball	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 18.4mm	Tapping Depth 18.4
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

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 2.60
2	External Relief Dia	6.5mm	82-25			Inner				82-15
3	External Relief Depth		11mm			5mm				
4	Inspection Done Before Hardening By (Name)					Ravi				
5	Material Sent For Hardening By (Name)					Lark Purra				
6	Material Sent For Hardening On Date			30	8	25				

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA