



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 Dlos)

S.No.	Check Parameter	Spoclfication	Observations	Remarks
1	Work Order No.		14522	30/66
2	Machined By		U.T.L. - m/c Shop	Prog No 320 (Rev 8)
3	Pallet Die No.		14767 (6.0 mm)	
4	Die Category	Drg. No.	M. Jumbo	Tapper 8°
5	Out Side Diameter	Drg. No.	580.1 mm Step 02 893 mm	Step length 31
6	Inside Diameter	Drg. No.	548.1 mm (Box 548.1)	Under cut 28.5
7	Width of Pellet Die	Drg. No.	195 mm	
8	Grooves as per Drawing	Drg. No.	32x7x9.1 / 32x7x9.1	(H=8)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No of
10	Drilling Area Surface Smoothness		OK	Male - 2 Both
11	Tapping Operator		m/c Shop	Side
12	Tapping PCD		619 PCD mm	Face side 30°
13	Tapping Hole Diameter		M16 2 Check by H16 R1	Tapping 30°
14	Tapping On Second Side	Half pitch of 1st side	OK	Both side
15	Tapping Hole Depth		32.5 mm Depth 33.1 mm	Tapping Depth - 31.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			mahesh 04/04/25	
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	30°
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter 30°
2	External Relief Dia	7.0 mm	outside	Inner
3	External Relief Depth		36	36
4	Inspection Done Before Hardening By (Name)		Mahesh	
5	Material Sent For Hardening By (Name)		Lark furnace	
6	Material Sent For Hardening On Date		04/04/25	
Inspected By (Sign) & Date			mahesh 04/04/25	

Reviewed by (Engineer-CNC)

Manager-QA